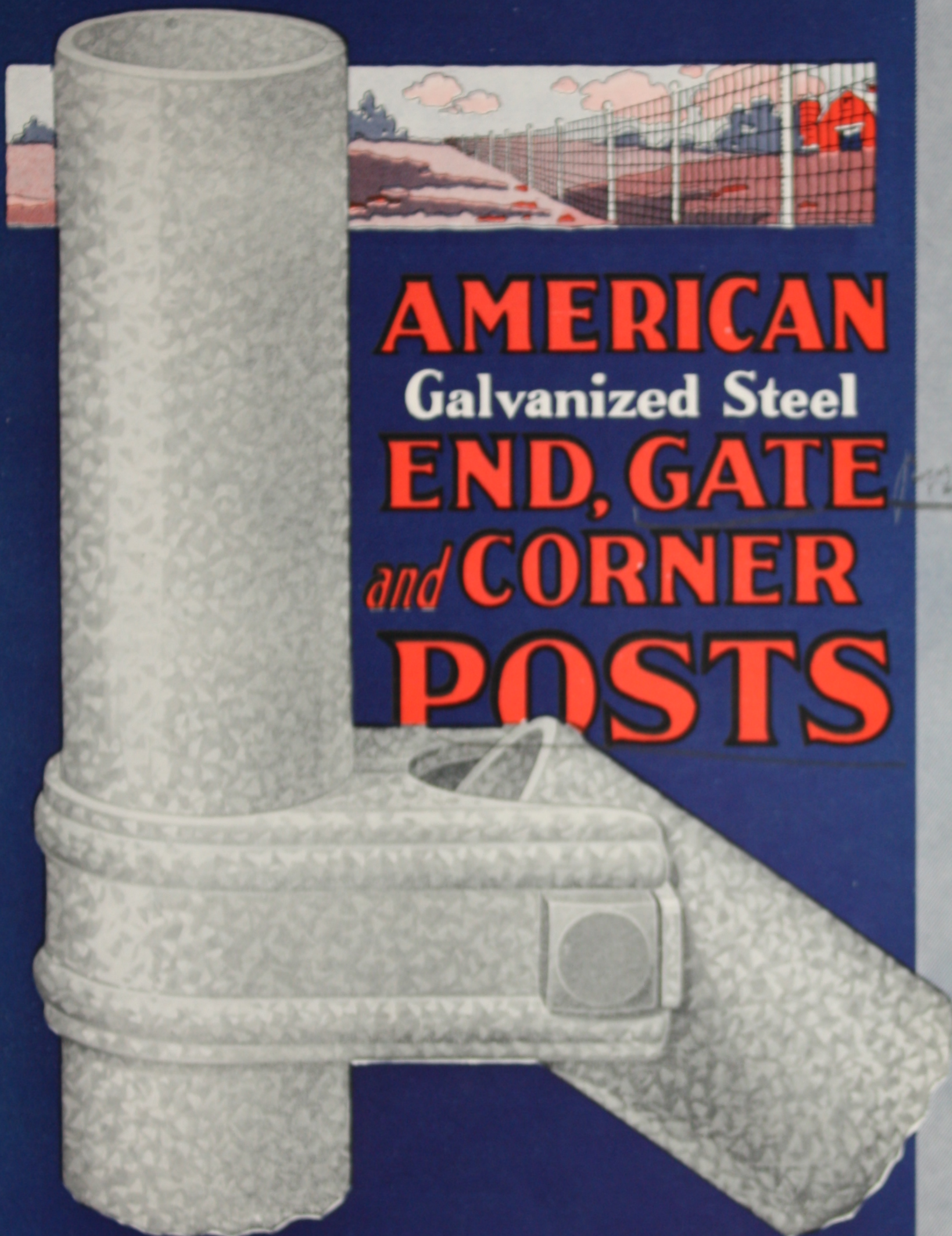


218-12.

JUN 28 '26

NOVEMBER 1925



# AMERICAN Galvanized Steel END, GATE *and* CORNER POSTS

**American Steel & Wire  
Company**

Chicago New York Boston Birmingham  
Dallas Denver Salt Lake City

U. S. Steel Products Company, San Francisco  
Los Angeles Portland Seattle



## American Galvanized End or Gate and Corner Fence Posts

The use of steel fence posts has become so general during recent years that there is no longer any question but what they are the only solution of the fence post problem. The history of American Galvanized Posts dates back many years and with satisfactory service under widely different conditions. They not only offer long life but are amply strong for every purpose.

By the development of new methods of making and galvanizing our posts, we are able to give you a heavier and better post. No other fence post offers the many advantages found in the American Galvanized Post, a few of which are given below.

### Strength Weight

The American Galvanized Fence Post is *stronger, heavier*—bigger and better in every way.

### Galvanizing

The galvanizing is done after the post is formed, ensuring a heavy protective covering inside and out, with an *extra heavy coat* below the ground line.

### Lasting Qualities

Our post has given excellent service for over 20 years and from all appearances will last many years longer. Zinc, which is used for Galvanizing, is the only metal that *will not* rust.

### Size

American posts are made from No. 8 gauge metal and are  $2\frac{1}{2}$  inches in diameter.

### Lightning Protection Burning Weeds Along Fence Line

Your fence is grounded wherever a steel post is used and danger to your stock from lightning is greatly reduced, also by their use you can burn the weeds along your fence lines without damage to fence or posts.

### Appearance

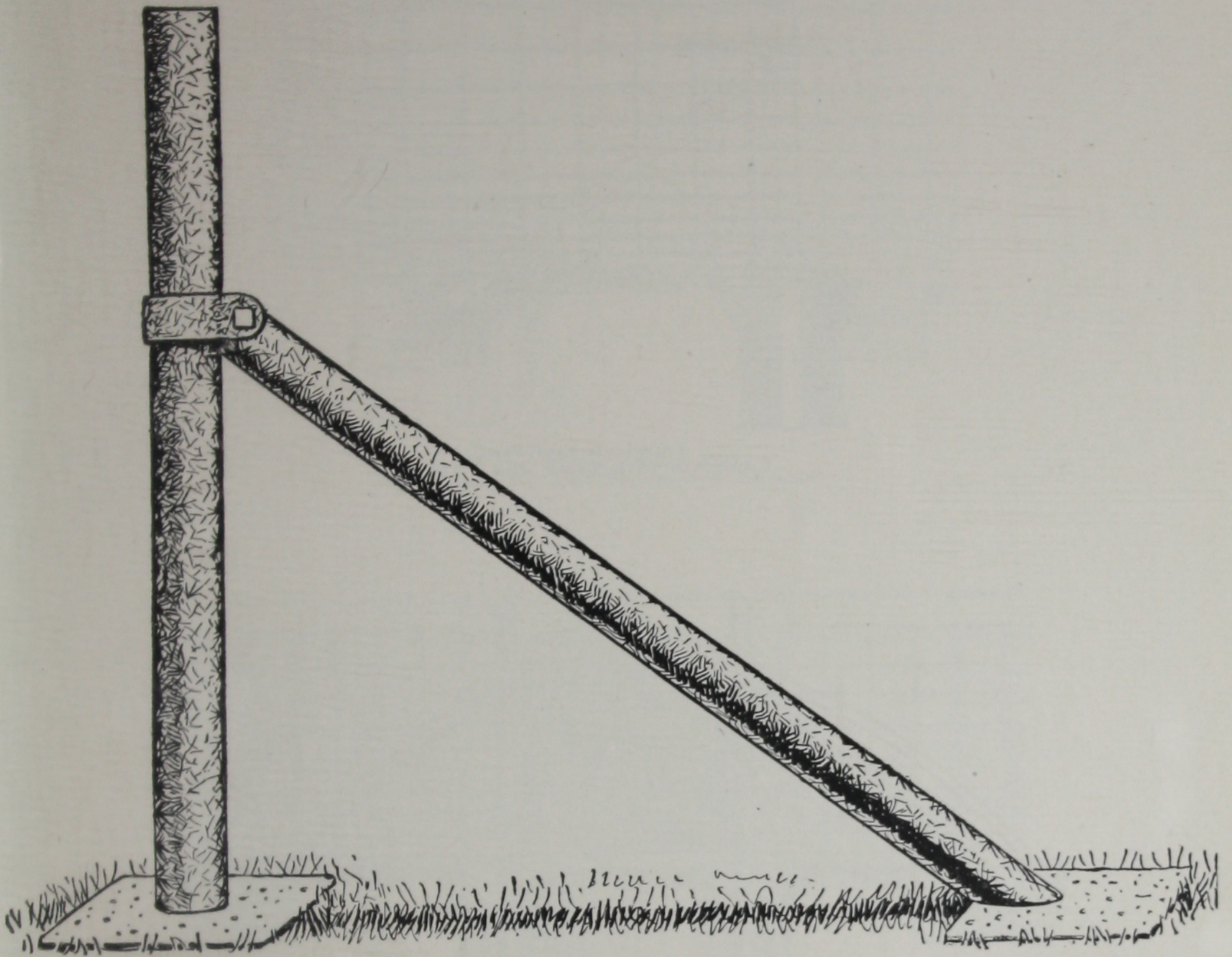
The uniform size, length and appearance of American Posts will add greatly to the attractiveness of your fence. Ornamental tops can be furnished for use where added attractiveness is desired.

### Wood Posts

Compare what we have told you above with the average life of wood posts, which is from 6 to 7 years, and we know your decision will mean the American Galvanized End Gate or Corner Posts will be used in all of your fences.



## American Galvanized End or Gate and Corner Fence Posts

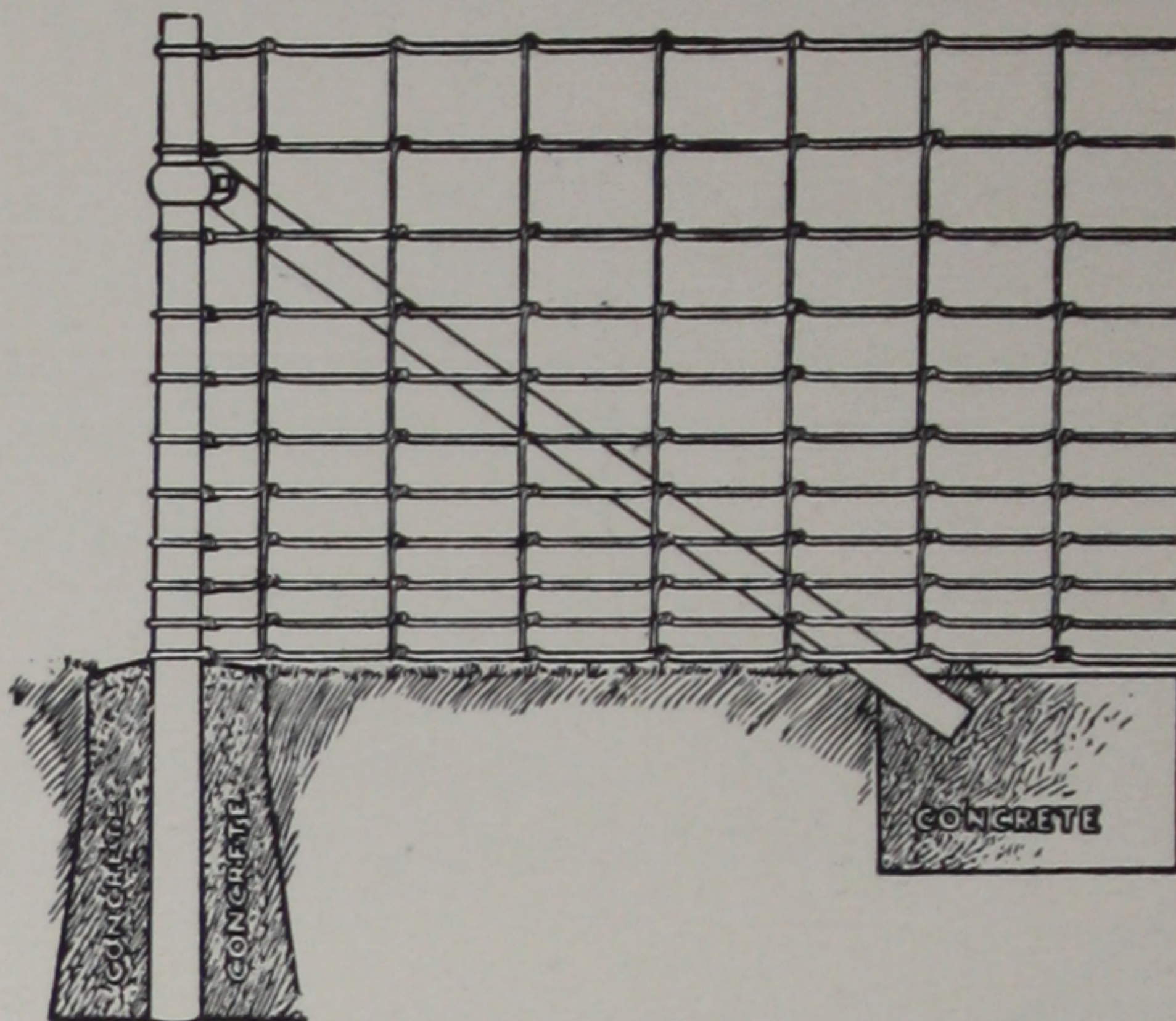


End and Corner Posts are the foundation of your fence. Build good foundations by using American End and Corner Posts. American Posts are  $2\frac{1}{2}$  inches in diameter and made from No. 8 Gauge Steel galvanized after forming. Properly set in concrete they will last a lifetime and stand any strain possible to exert in stretching fence.

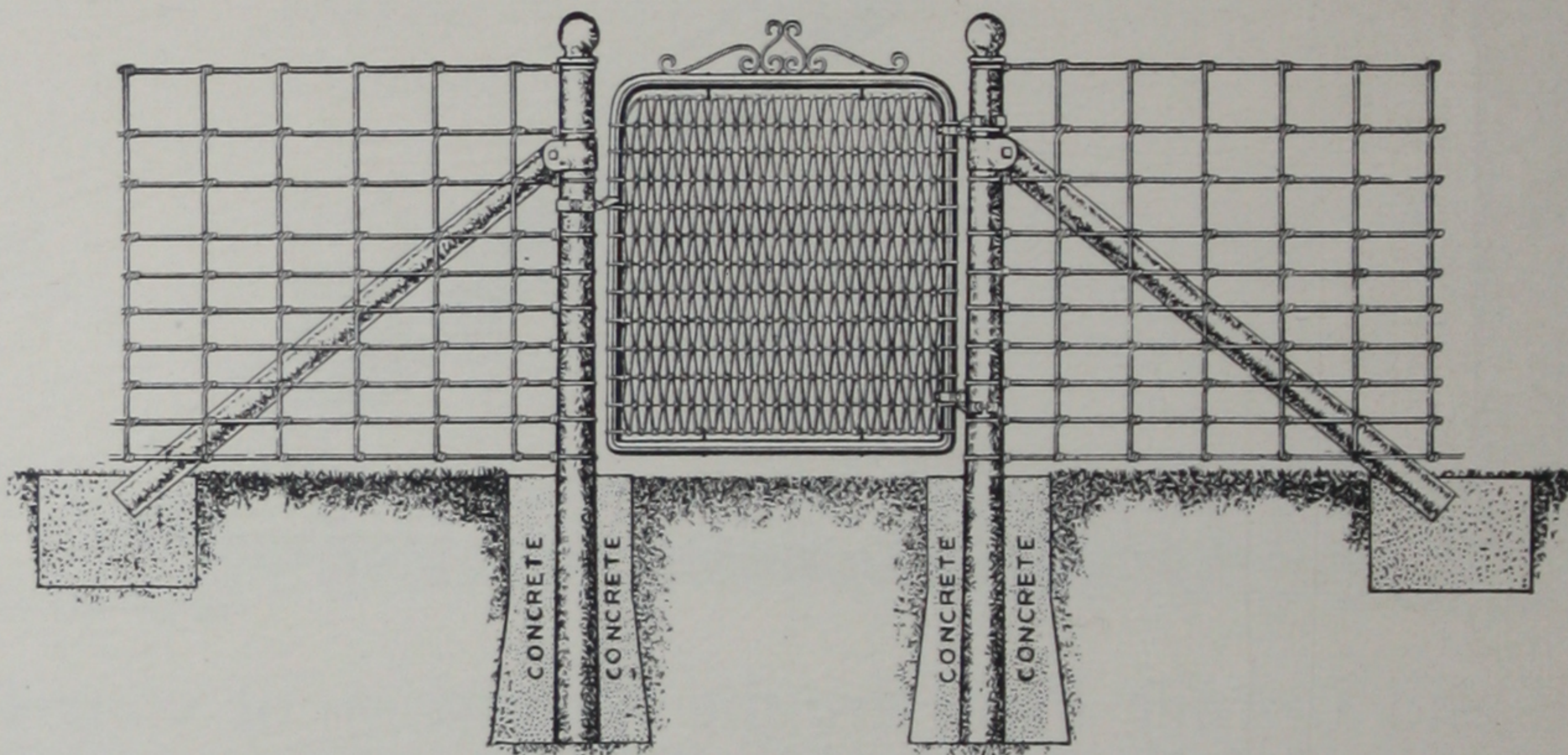
End and Corner Posts are furnished in 6, 7,  $7\frac{1}{2}$ , 8, 9, 10 and 11 ft. lengths, and with all necessary fittings and braces. The End or Gate Post has one brace. The Corner Post, two, except in the 10 and 11 ft. lengths. For these sizes two braces are furnished with the End or Gate Post and four with the Corner Post.



## American End or Gate Post



American End Post  
Complete with Brace and Fittings



American End Post  
Used For Hanging Gates

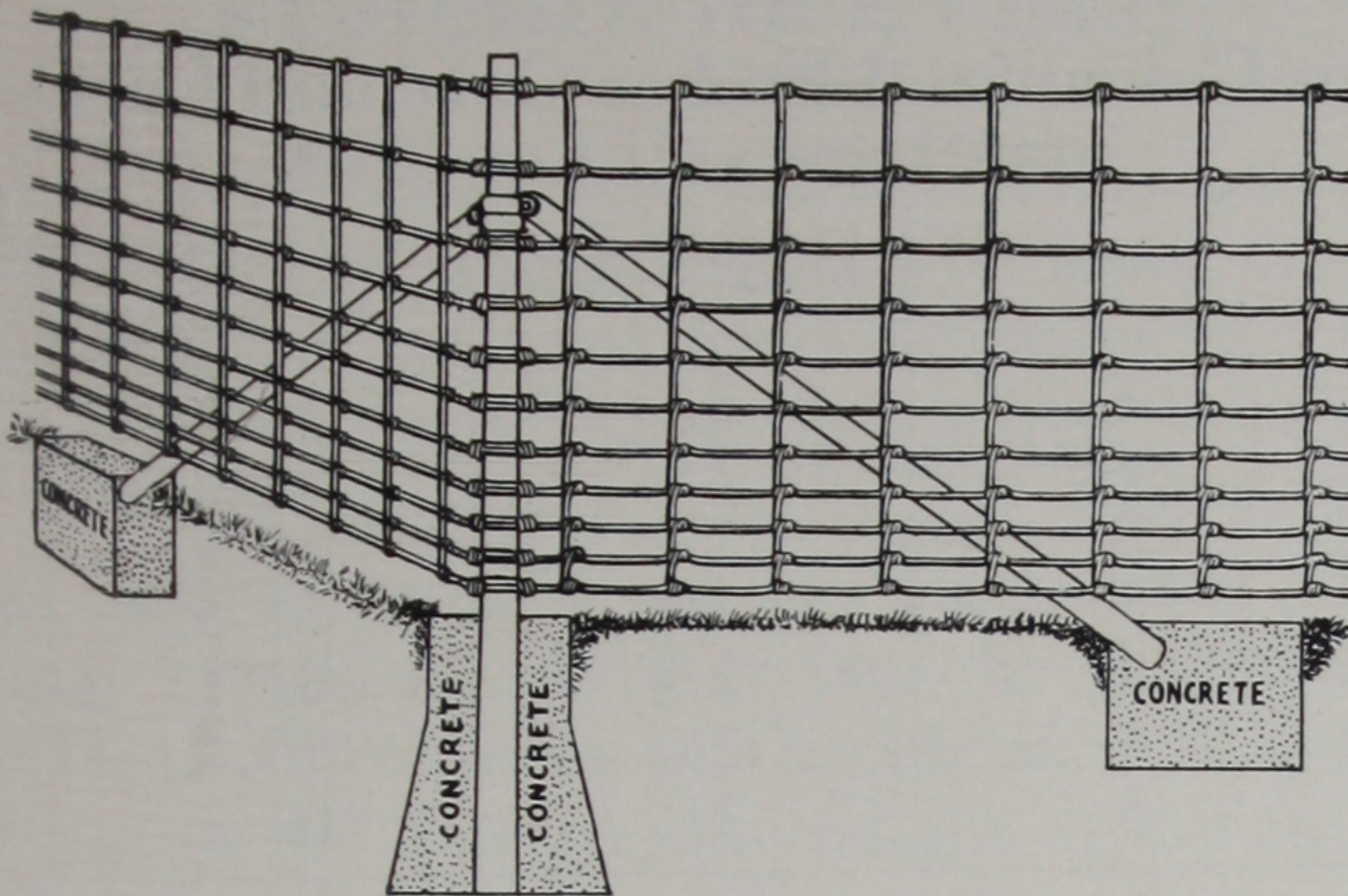
End and Corner Posts are the foundation of your fence. Build good foundations by using American End and Corner Posts. Made from No. 8 Gauge Steel, 2½ inches in diameter. Properly set in concrete they will last a lifetime and stand any strain possible to exert in stretching fence.

End and Corner Posts are furnished only in the following heights: 6, 7, 7½, 8, 9, 10, 11 feet.

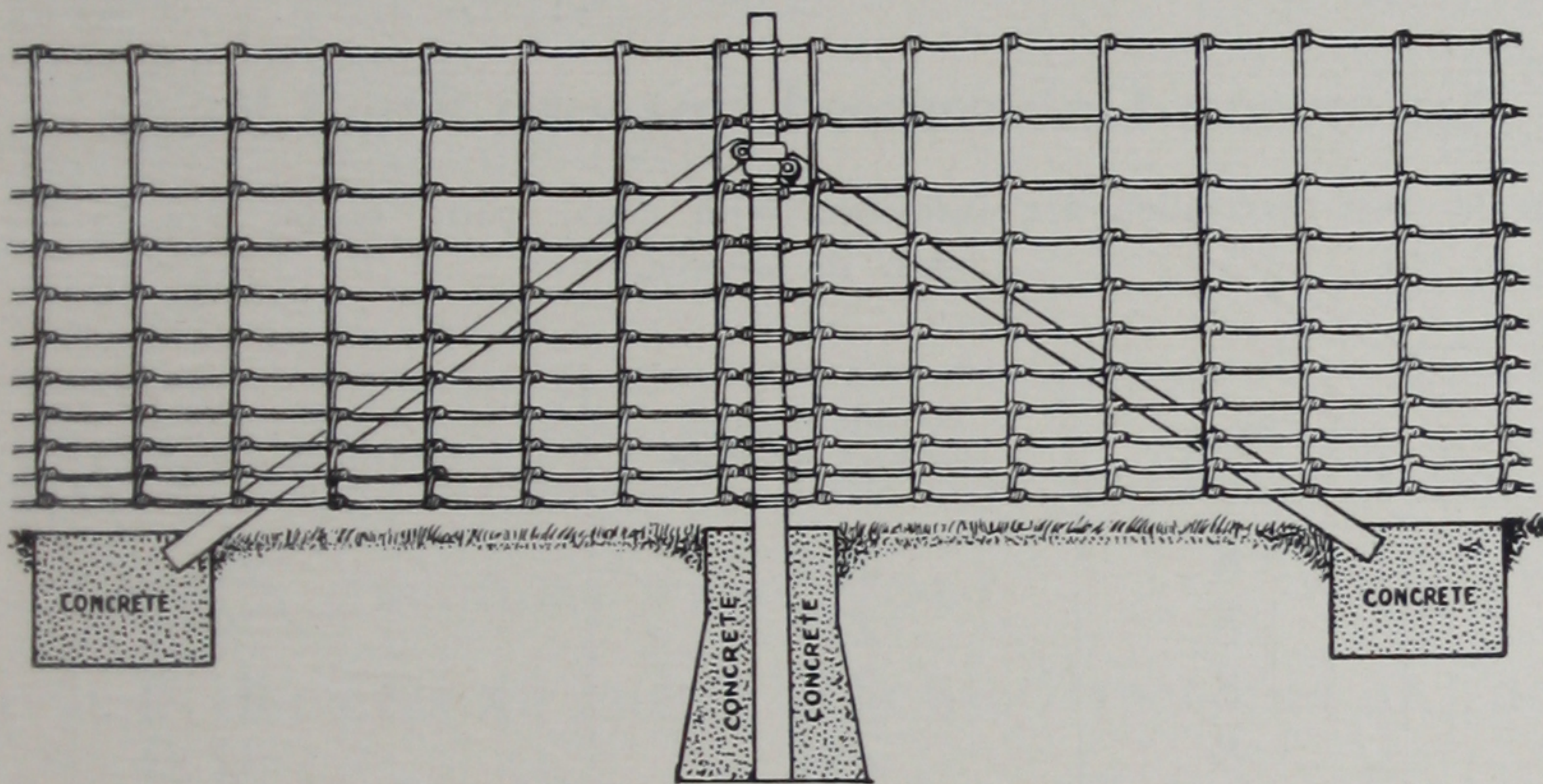
See next page for illustration of Corner Post.



## American Corner Posts



American Corner Post  
Complete with Two Braces and Fittings



American Corner Post  
In Use as Intermediate Stretching Post

American End and Corner Posts are made of No. 8 gauge steel  $2\frac{1}{2}$  inches in diameter and they are amply strong for the purpose and their use ensures better and more satisfactory service from both wire fence and posts.



# Specifications and Weights

## American Galvanized End or Gate and Corner Posts

Length in Feet	Gauge	Top and Bottom Diameter in Inches	Approximate Weight in Pounds	
			End or Gate	Corner
6	8	2 1/2	46.0	64.9
7	8	2 1/2	48.3	67.7
7 1/2	8	2 1/2	51.9	72.7
8	8	2 1/2	54.5	75.9
9	8	2 1/2	62.1	86.7
*10	8	2 1/2	96.1	151.4
*11	8	2 1/2	100.3	155.6

\*10 and 11 foot End Posts are furnished with two braces. Corner Posts are furnished with 4 braces.

Ornamental Ball Tops can be furnished for End or Corner Posts.

## American Galvanized Smooth Steel Posts

No fittings of any description are furnished with above posts, except Ornamental Tops when so ordered.

Length in Feet	Gauge	Top and Bottom Diameter in Inches	Approximate Weight in Pounds
6	8	2 1/2	27.1
7	8	2 1/2	29.1
7 1/2	8	2 1/2	31.0
8	8	2 1/2	32.9
9	8	2 1/2	36.6
10	8	2 1/2	40.4
11	8	2 1/2	44.1

## American Galvanized Smooth Steel Posts are Especially Adapted for—

Street and other Sign Posts, Road Markers, Telephone Lines, Whistle Board Posts, Railroad Crossing Posts, Mail-box Posts, Lamp Posts, Flag Staffs, Tent Poles, Clothes-line Posts, Tennis Court Posts, Trellises, etc.

Whenever it is desired to place wood or metal signs on American Smooth Steel Posts by the use of bolts, we furnish the posts with holes bored to suit requirements at slight additional cost. Smooth posts furnished with or without ball tops.



# Lengths of Posts Required for Various Heights of Fence

## End and Corner Posts

The height of the completed fence determines the length of the post necessary. It has been satisfactorily proven that for best results End and Corner Posts should be set in concrete not less than 3 feet, that is, the concrete about the base of the End and Corner Posts should extend into the ground not less than 3 feet. The lower end of the post may extend still further into the ground and below the concrete. Hence to determine the length of End and Corner Posts add to the 3 feet in the concrete, the height of the fence used and 2 inches for lee-way at top of the fence.

Thus in building a 50-inch fence you would figure as follows:

Depth of post in the ground .....	36 inches
Height of fence.....	50 inches
Height of post above fence.....	2 inches
<hr/>	
Total.....	88 inches
	or 7 feet. 4 inches.

You would therefore buy  $7\frac{1}{2}$  foot End or Corner Posts.

For ordinary conditions we suggest—

For fence not over 46 inches high use 7 foot End or Corner Post.

For fence not over 52 inches high use  $7\frac{1}{2}$  foot End or Corner Post.

For fence not over 58 inches high use 8 foot End or Corner Post.

For fence not over 72 inches high use 9 foot End or Corner Post.

For fence not over 80 inches high use 10 foot End or Corner Post.

For fence not over 88 inches high use 11 foot End or Corner Post.

*American End and Corner Posts should always be set in concrete.*

In building very heavy high fences it is always advisable to set End and Corner Posts as securely as possible and the concrete may advantageously extend to a depth of 4 feet (or more) in the ground.



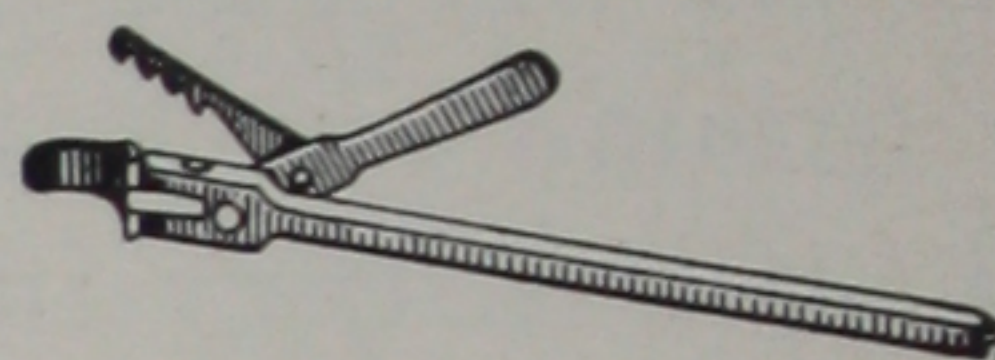
## Post Fittings and Tools

For Use With American End or Gate and Corner Fence Posts

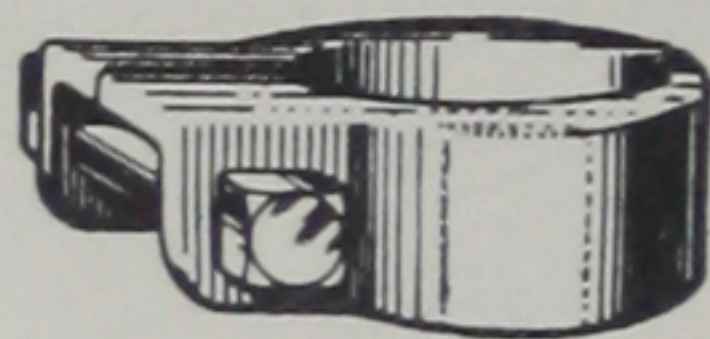


No. K271

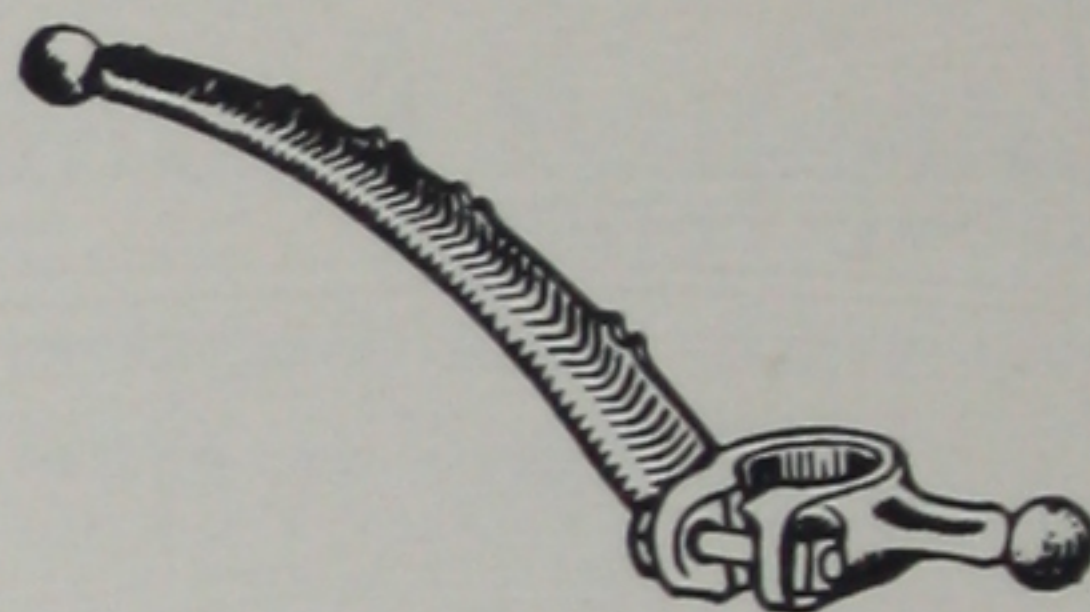
Ornamental Top  
For End and  
Corner Post



Perfection End Post Tool



No. K-14  
Brace Collar



No. K35  
Extension Arm for  
End and Corner Post



Brace  
for End and  
Corner Post

Number	Description	Approximate Weight
		Pounds
K271	Ornamental Top for 2½ inch End and Corner Post.....	2.82
K14	Brace Collar (complete with bolt) for 2½-inch End and Corner Posts.....	1.1
None	6 foot x 2½-inch Brace for 6 and 7 foot End and Corner Posts.....	17.3
None	6½ foot x 2½-inch Brace for 7½ foot End and Corner Posts...	18.8
None	7 foot x 2½-inch Brace for 8 foot End and Corner Posts.....	20.2
None	8 foot x 2½-inch Brace for 9 foot End and Corner Posts.....	23.1
None	9½ foot x 2½-inch (Upper) Brace for 10 and 11 foot End and Corner Posts.....	27.5
None	7¾ foot x 2½-inch (Lower) Brace for 10 and 11 foot End and Corner Posts.....	22.4
K35	12 inch Extension Arm for American End and Corner Posts....	5.75
None	Perfection American End Post Tool.....	3.

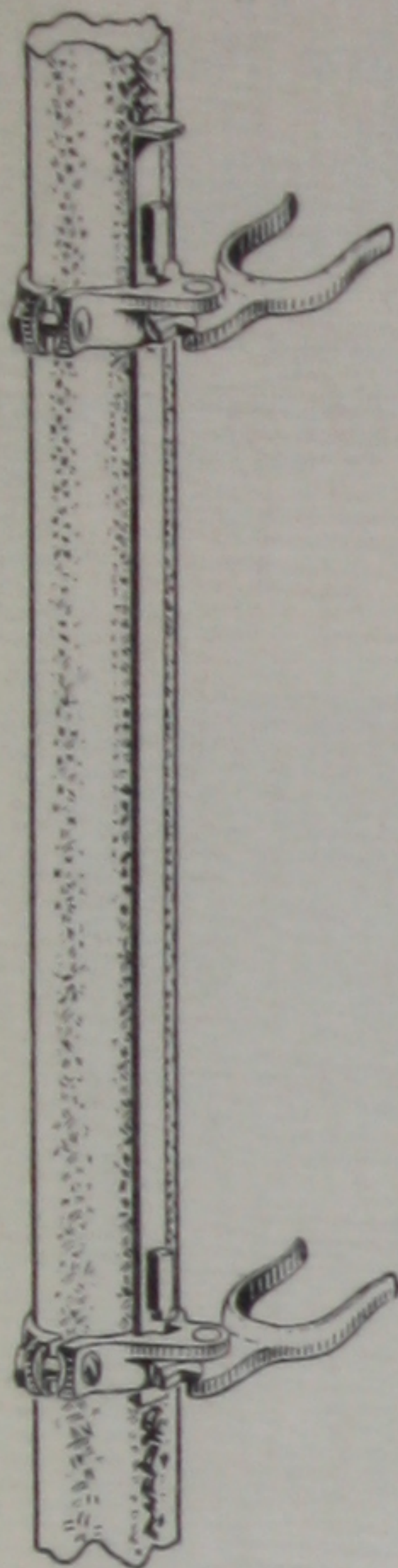
Order by Number and Description

Ask Your Dealer for Prices

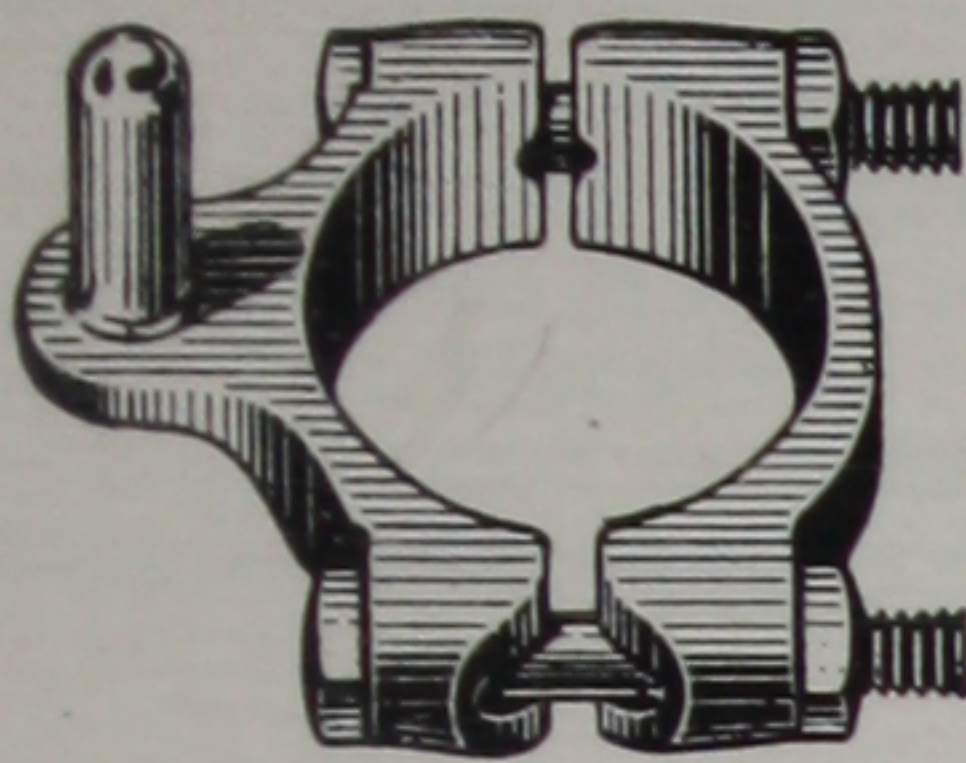


# Gate Fixtures

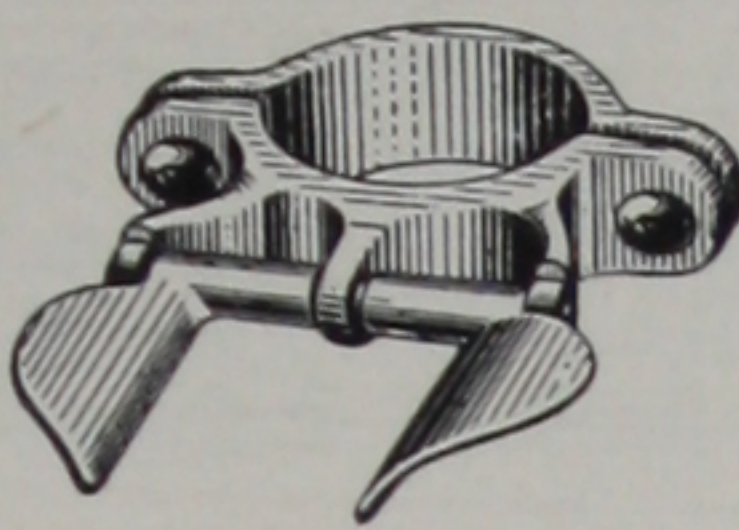
For Hanging American Steel Gates on American Galvanized Steel  
End or Gate and Corner Posts



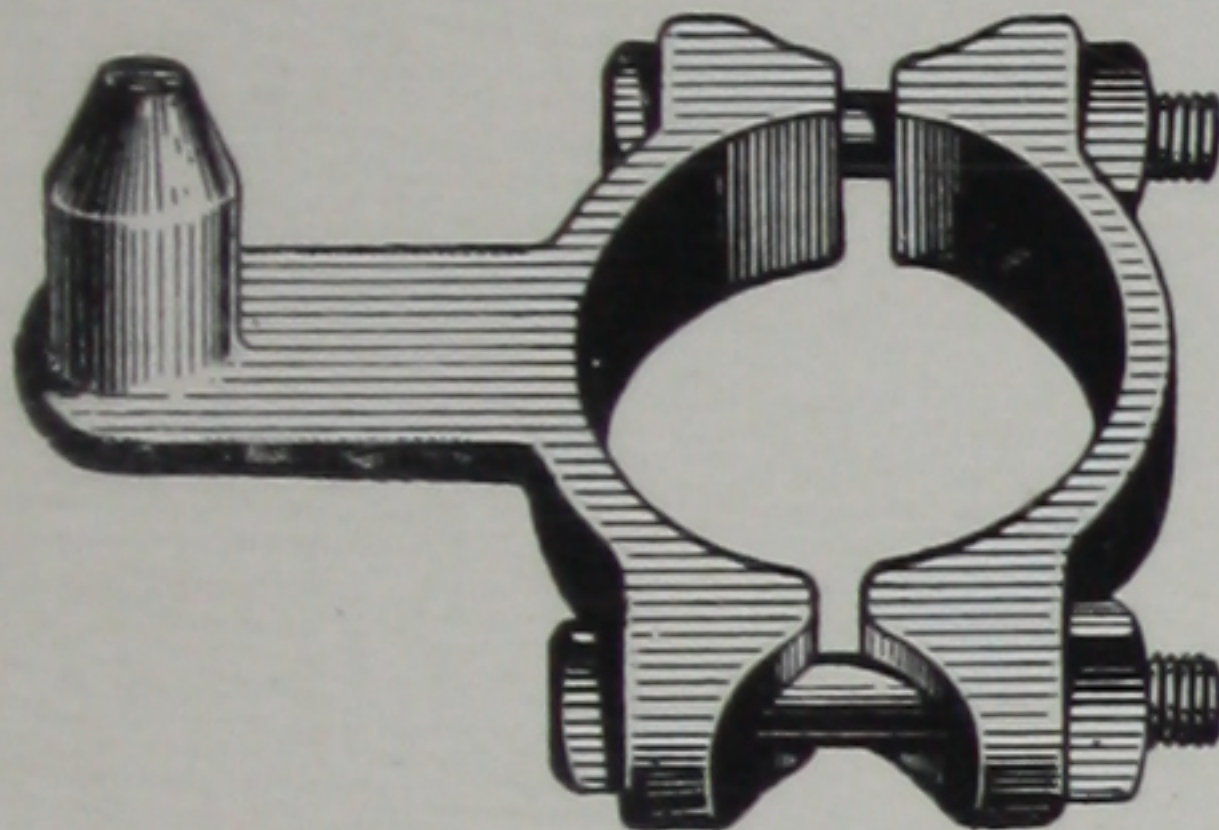
Double Fork  
Latch to  
Attach to  
Steel Post  
No. K901



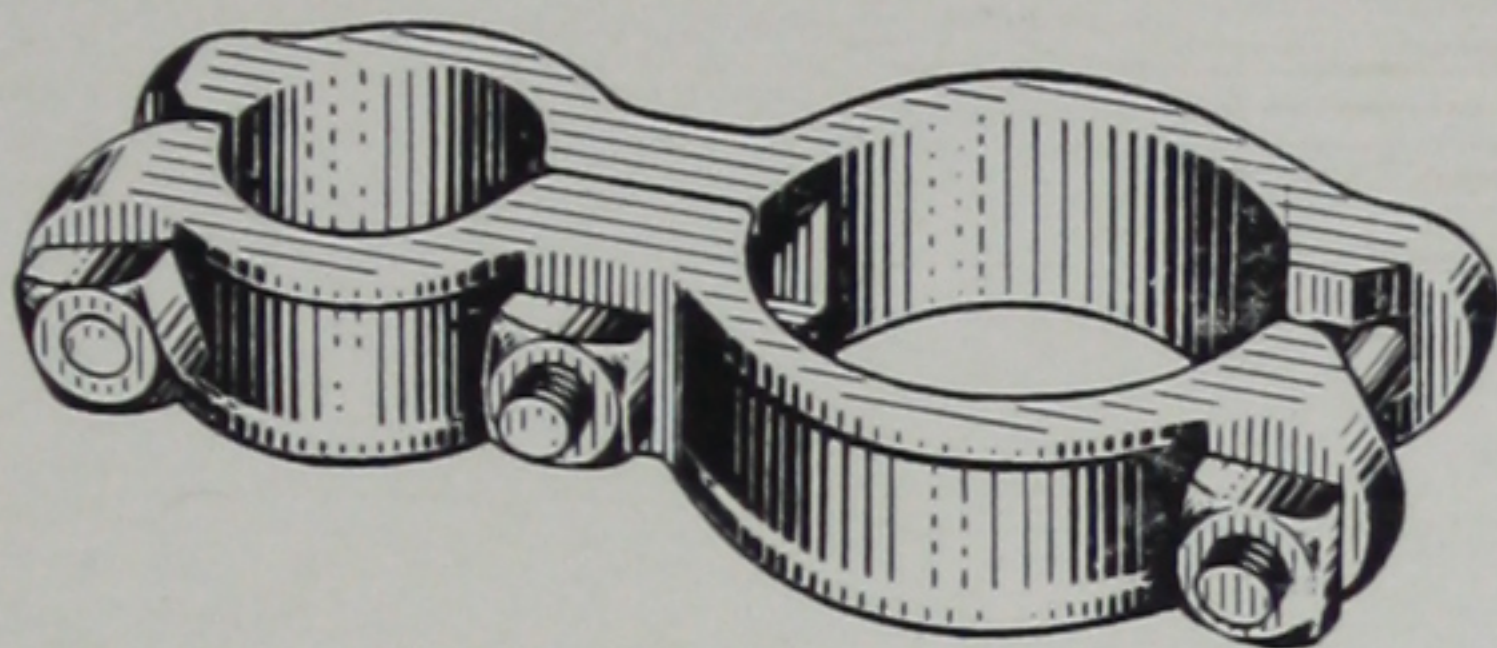
No. K3145-A. Top or Bottom  
Hinge-collar



No. K7156. Pig Ear Latch



No. K3134  
Latch Bar Holder  
for Steel Posts



No. K3122  
Top or Bottom Hinge  
For Tilting Gates



No. K-3636-A  
Latch Bar Complete  
with Top and Bottom  
Holder for 50"  
Tilting Gate  
Note—K-3134 is Used  
for Latch Bar Holder

Number	Description	APPROXIMATE WEIGHT	
		Pounds	Ounces
For American Walk, Poultry Yard and Single Drive Gates			
K3145-A	Hinge-collar, complete with bolts.....	2	
K7156	Pig Ear Latch, complete with bolts.....	2	5
For American Tilting Gates			
K3134	Latch Bar Holders.....	2	9
K3122	Hinge, complete with bolts.....	2	3
K3636-A	Latch Bar Complete with Top and Bottom Holders for 50" Gate.....	9	15
K3636-B	Latch Bar Complete with Top and Bottom Holders for 55" Gate.....	10	7
K369-B	Latch Bar (Specify Height of Gate), for 50" Gate.....	5	1
	Latch Bar (Specify Height of Gate), for 55" Gate.....	5	9
K901	Double Fork Latch to attach to 2½" Steel Post.....	3	12
-			
For American Park and Paddock Gates			
K3145-A	Hinge-collar, complete with bolts.....	2	
K7112	Pig Ear Latch, complete with bolts.....	2	5

Order by Number  
and Description

American Posts are Heavily Galvanized

Ask Your Dealer  
for Prices



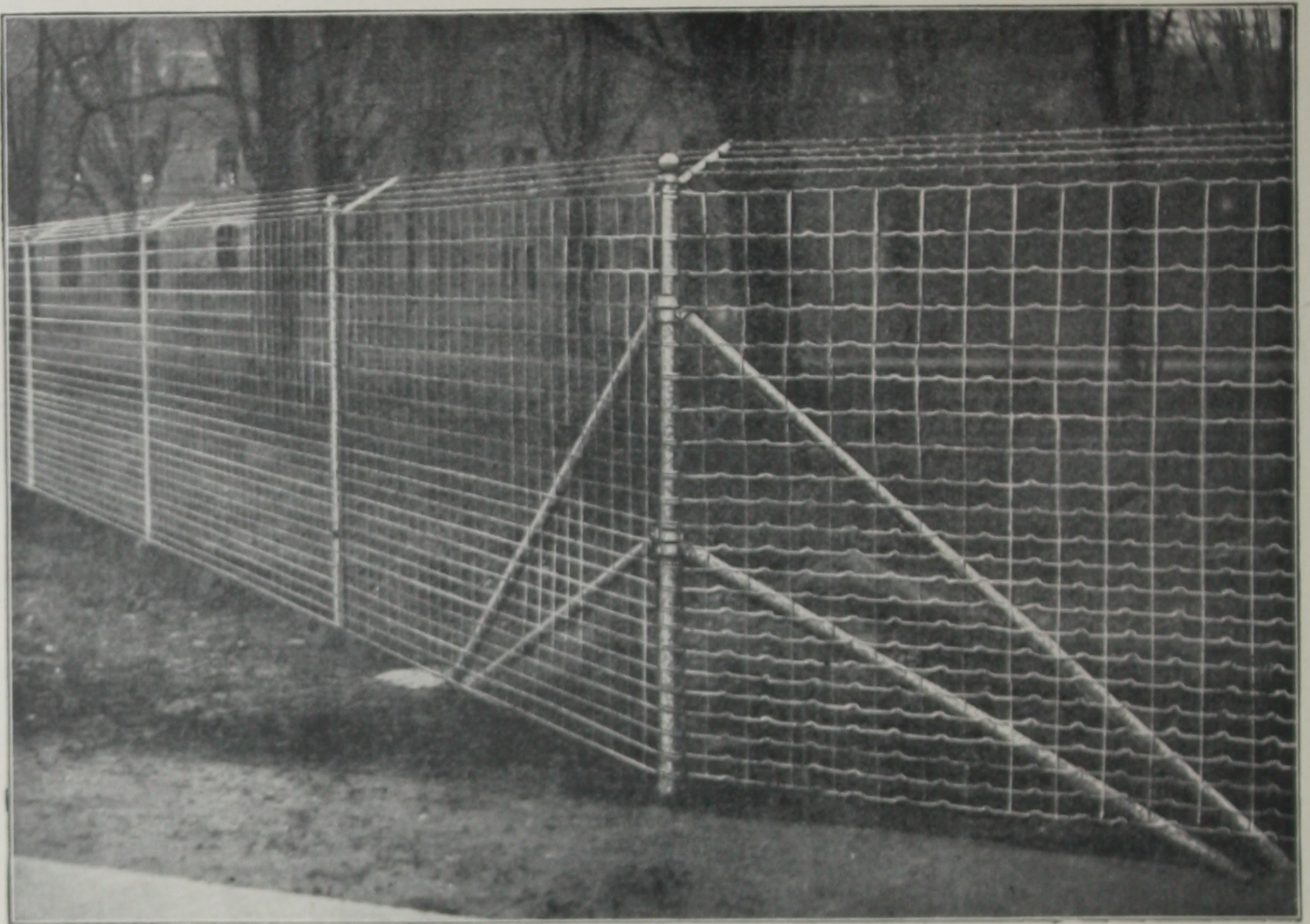
## 10 and 11-foot American Galvanized Steel Fence Posts

(For Use with High Fences)

These posts are used for enclosures where high fences are required, such as Stallion Paddocks, Deer Parks, Institutions, Factories, etc.

The 10 and 11-foot End Posts are equipped with two extra strong braces and Corner Posts with four braces. As shown in the illustration below, the braces are of different lengths, one placed below the other on the posts. The ends of the braces, however, rest in one brace block.

The higher and heavier the fence, the greater the strain on the end and corner posts. Therefore these posts must be firmly set and anchored with a sufficient body of concrete to hold them. Other things being equal, 10 and 11-foot end and corner posts require approximately from  $\frac{1}{3}$  to  $\frac{1}{2}$  more bulk in concrete than posts of ordinary height.



Showing 11-Foot Corner Post properly set, with 4 Braces  
Also showing use of Extension Arms, carrying four strands of barbed wire

### Extension Arms

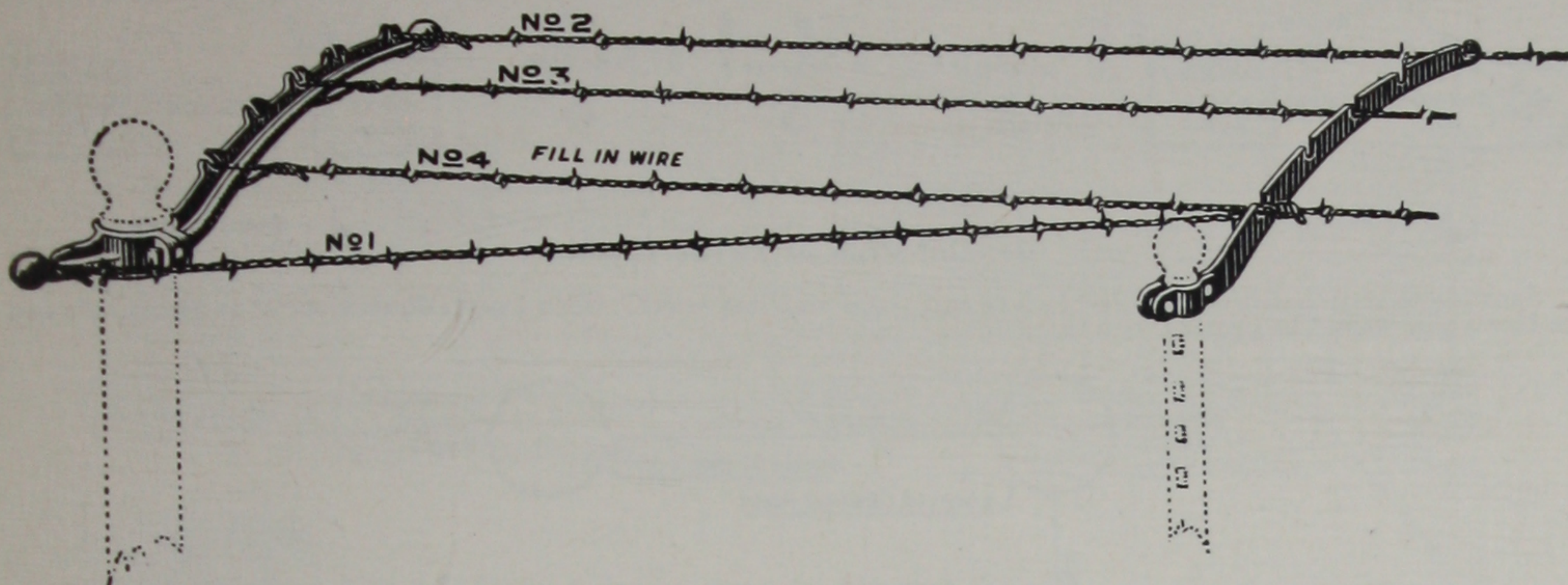
On the next page will be found directions for stretching Barbed Wire on Extension Arms. This method of making fencing non-climbable has been widely adopted and has proven very satisfactory. It provides the greatest protection possible to secure from a Wire Fence and adds but little to the cost of the structure. We recommend that, wherever fencing is erected 6 feet and over in height, this method be followed so as to insure complete protection.



# Barbed Wire Extension Arms 12 inches Long

For Use With American Galvanized Steel Fence Posts

Illustrating 2 Methods of Fastening Barbed or Smooth Wire on End or Corner Posts



**Plan No. 1—3 Wires**

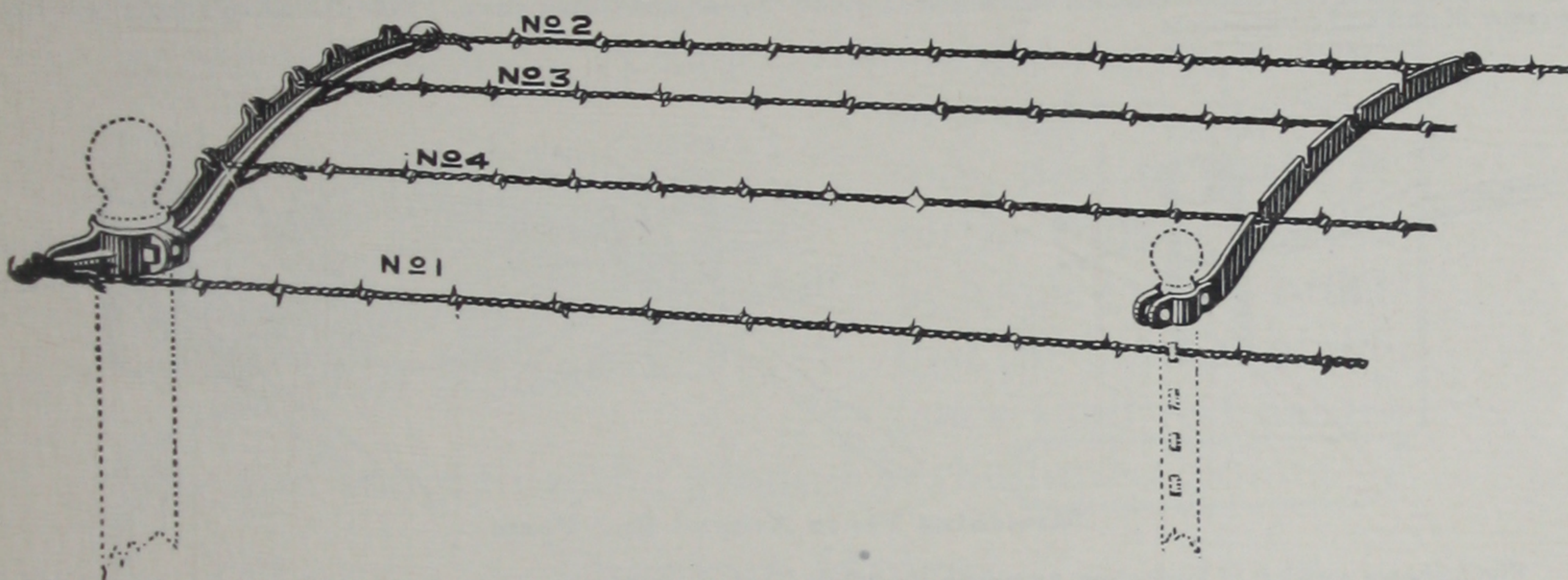
1st. Set the end post arm at right angles to the fence line, inside or outside of the fence as desired, place the ornamental top in position and clamp the arm to the post securely. Set the arm at the other end of stretch in the same manner.  
2nd. Tie wire No. 1 to the knob "A" on one arm then make the stretch from the opposite end post and tie that

end of wire No. 1 to the knob on the opposite arm.

3rd. Next stretch wire No. 2, then wire No. 3.

4th. Fill in the space between wires No. 1 and No. 3 with the short wire No. 4 by splicing wire No. 4 to wire No. 1 at the point "B," then stretch and tie to the end post arm.

4 wires may be used with plan No. 1 if desired.



**Plan No. 2—4 Wires**

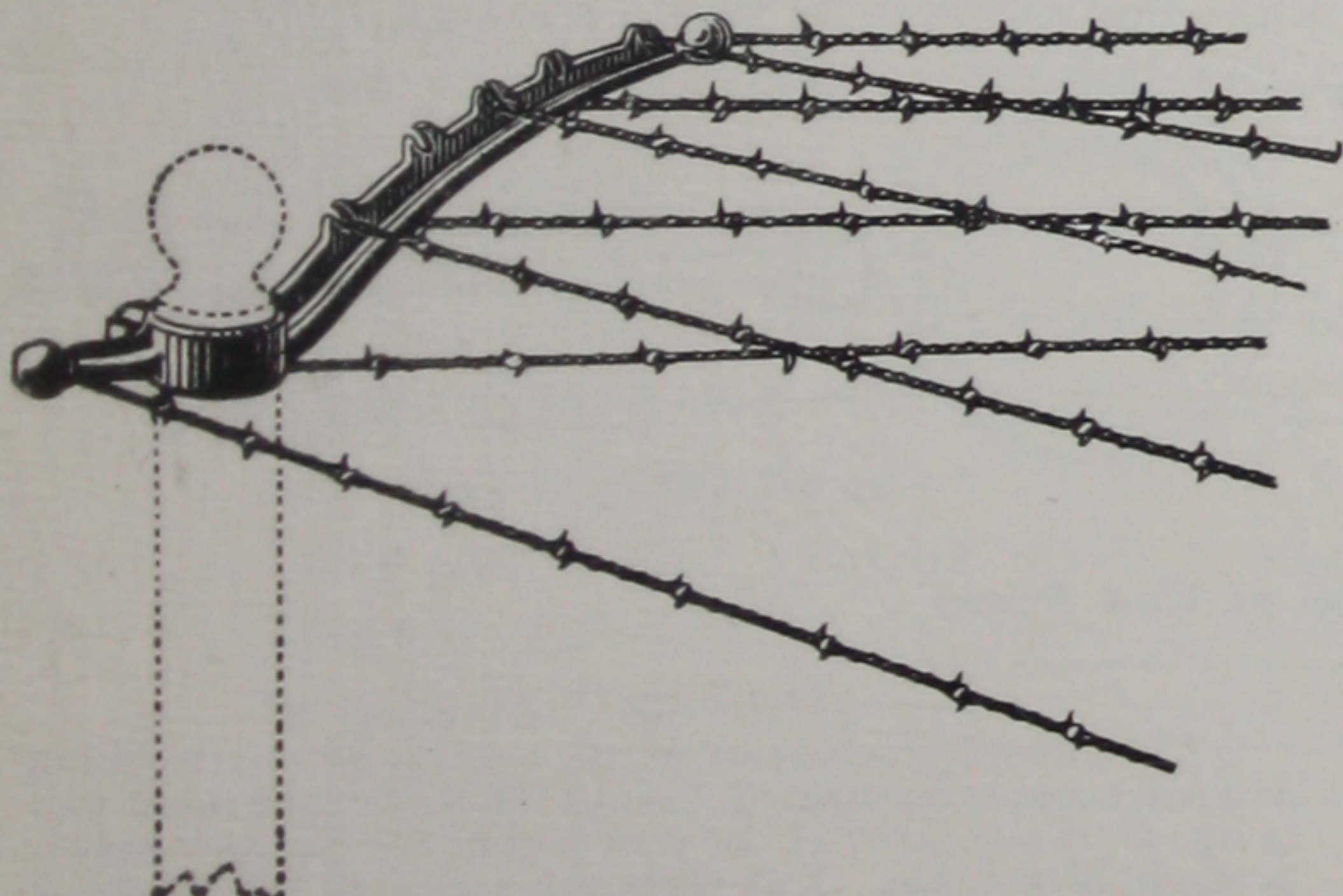
1st. Set the post arms as directed in plan No. 1.

2nd. Stretch wire No. 1 and fasten to the line posts at the top tongues.

3rd. Stretch wires No. 2, 3 and 4.

5 wires may be used with plan No. 2 if desired.

The corner, end and line posts in plan No. 2 should extend above the ground 3 inches more than in plan No. 1, so as to allow a 3-inch space between the top of the woven wire and barb wire No. 1.



**Corner Post Extension Arm**

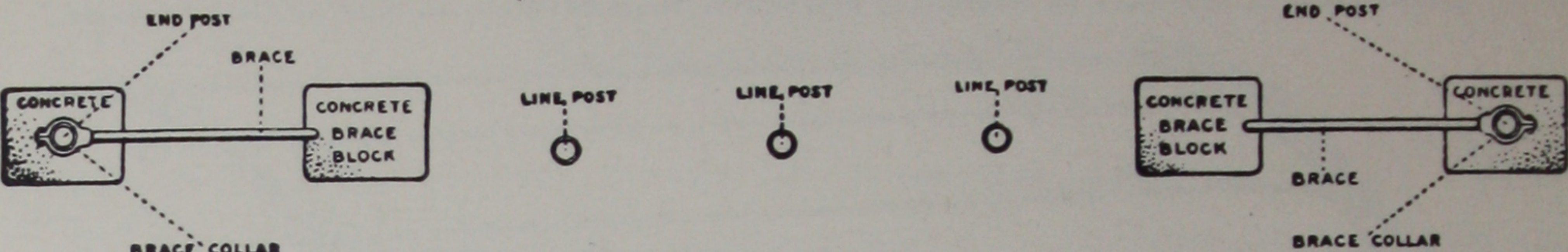
The end post extension arm is also used for the corner post by setting the arm one half way between the fence lines as shown above.

American Posts are Heavily Galvanized with an Extra Heavy Coat on the Part Which Goes into the Ground



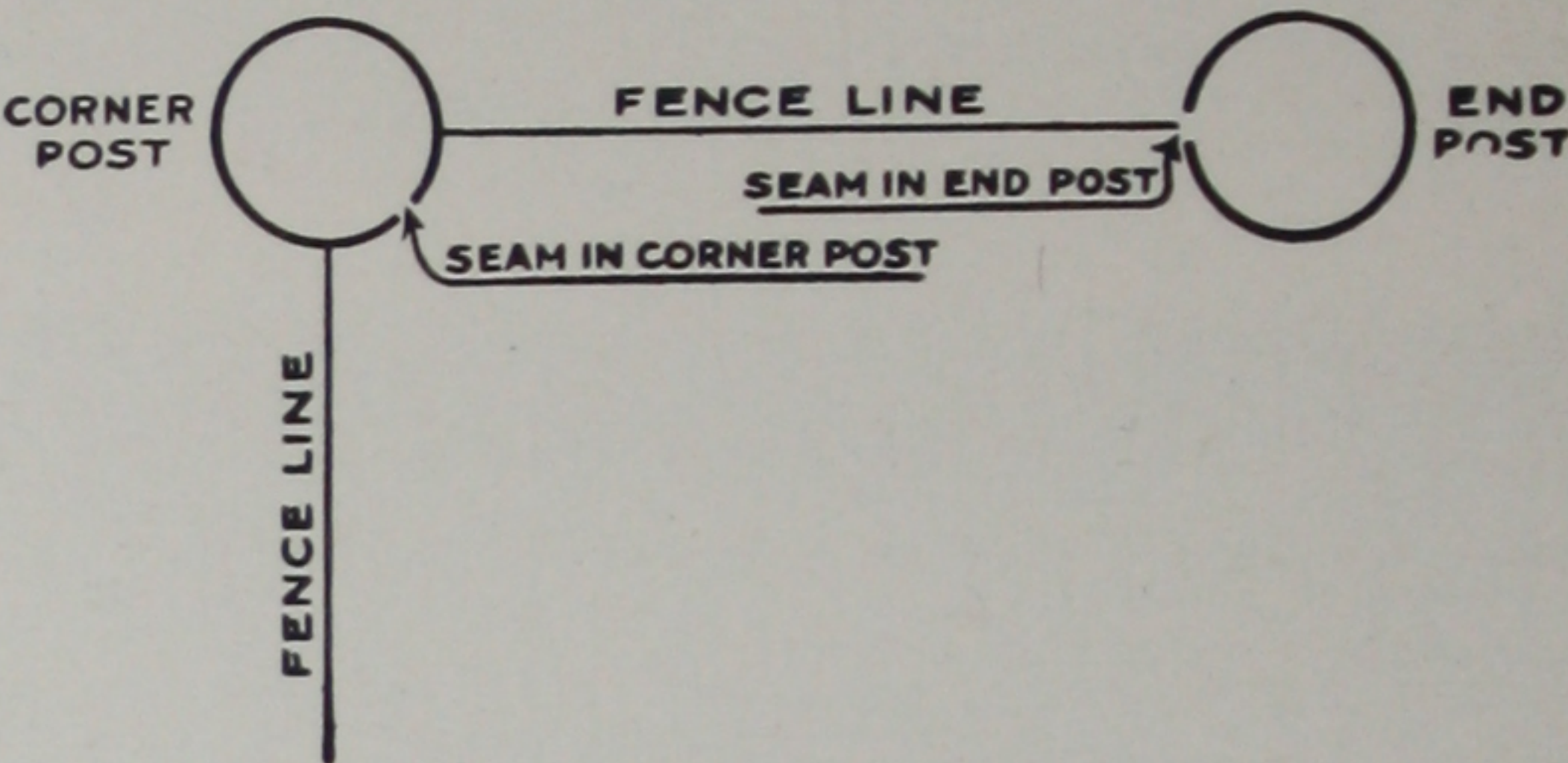
# General Suggestions for Fence Building with American Galvanized Steel Posts

(Read Carefully, Pages 13 to 18)



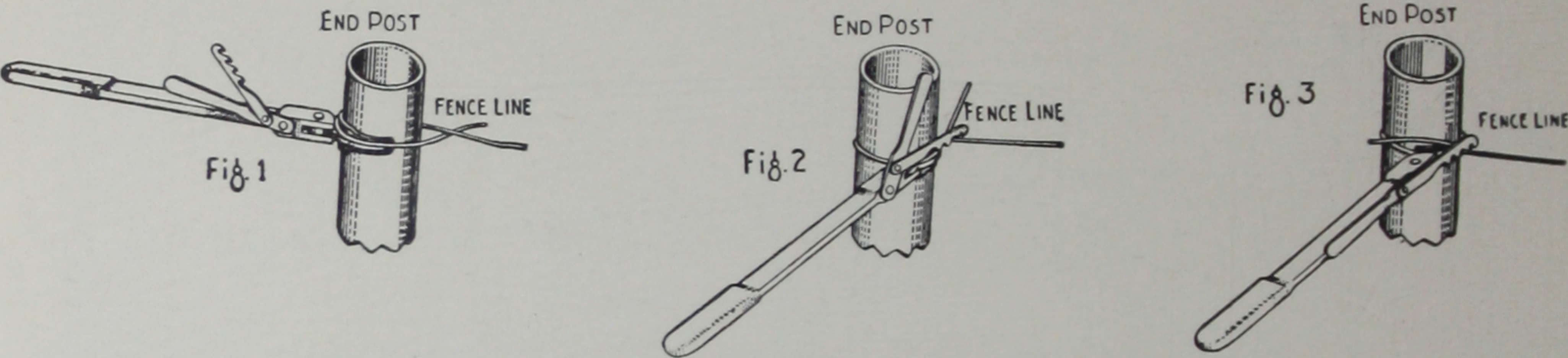
Ground Plan of Fence Line

Showing relative position of brace-block to end posts and line posts. Note longer dimensions of end-post-hole and brace-block-hole should be parallel with fence line.



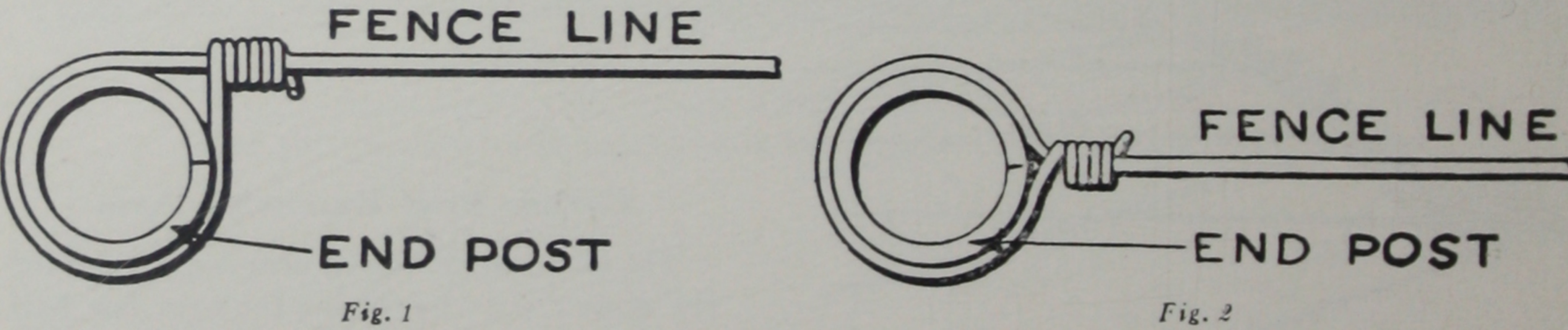
Position of End and Corner Posts

Here is shown the relative position of the wire fabric to the end and corner posts. Note the fence should pull from the center of end and corner posts.



Stretching Fence Around End Posts

Fig. 1 shows position of Perfection American End Post Tool after having engaged the end of fence wire, ready to pull around end post, to place.   
 Fig. 2 shows position after bringing end of wire to proper place for fastening—with lever hook in position to fasten over fence wire.   
 Fig. 3 shows position of wires ready for splicing. Fence line wire has been brought to center of post by means of lever hook.



Fastening Wires at End Posts

## The Wrong Way

Fig. 1 shows the usual tie secured about the End Post. This tie doesn't hold the fence taut, because the loop will slip around on the post until the line wires pull from the center of the post. This slacks the fence.

## The Right Way

Fig. 2 shows the correct position of tie when stretching and fastening is completed. Note the bars of the fence pull in line from the center of the post and no further movement, or slack, is possible. This tie is accomplished by the use of the American End Tool, illustrated above.



# Fence Building

## With Steel Fence Posts



**F**ENCE building is greatly facilitated if, at the outset, the fence line is properly cleared of brush, stumps, rocks and other obstructions which, if not taken into consideration, will interfere with the lining up of the posts and stretching of the wire fabric. A fence should be pig tight and



hog tight at the bottom, and to make it so the humps should be leveled off in order that the bottom of the fence shall rest natur-

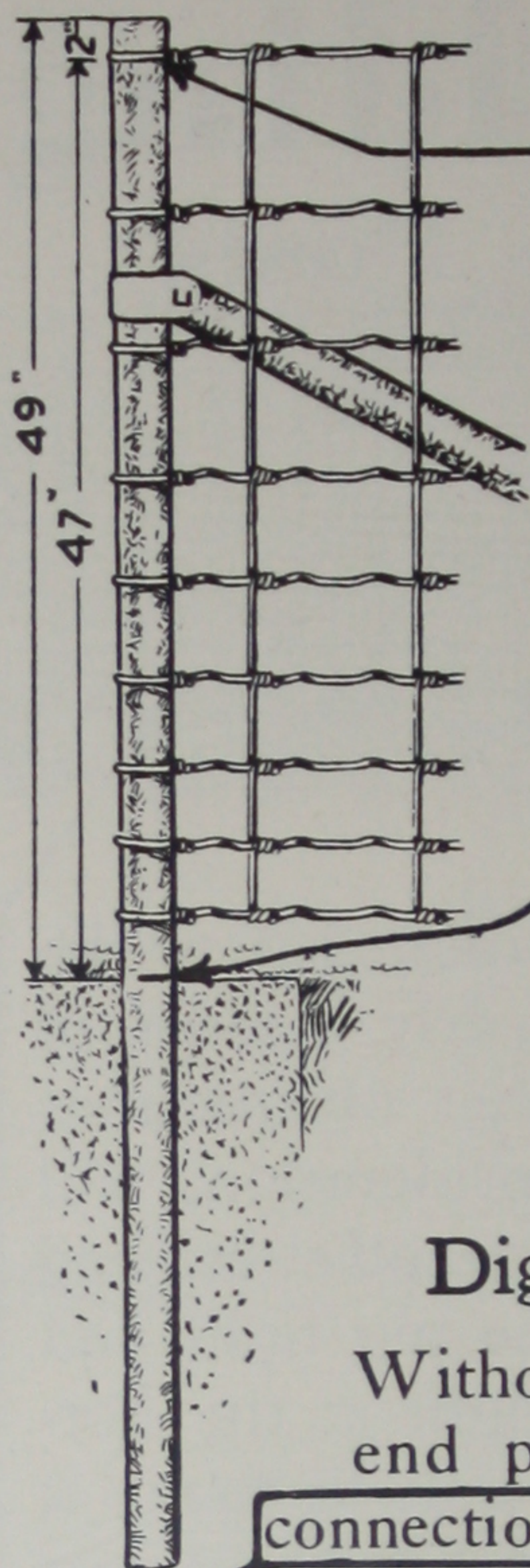
ally and snugly on the ground at the lowest points.

### Digging Holes

The next step is to dig holes for end posts and corner posts. Wherever a gate is to be placed in the fence line, two end posts will be necessary. If the gate is placed at a corner, two end posts will answer—one at the corner, the other at the opposite end of the gate. Under ordinary conditions, with soil fairly firm and not too wet, the hole for the American steel end post may be in size 18 inches by 20 inches, the longer dimension being parallel with the fence line. Set the post not less than 3 feet deep, and even deeper if the post will admit being more than 3 feet in the ground and leave enough above ground to carry the fence. Corner posts, under normal conditions, require a hole whose dimensions are 20 inches by 20 inches and not less than 3 feet deep.

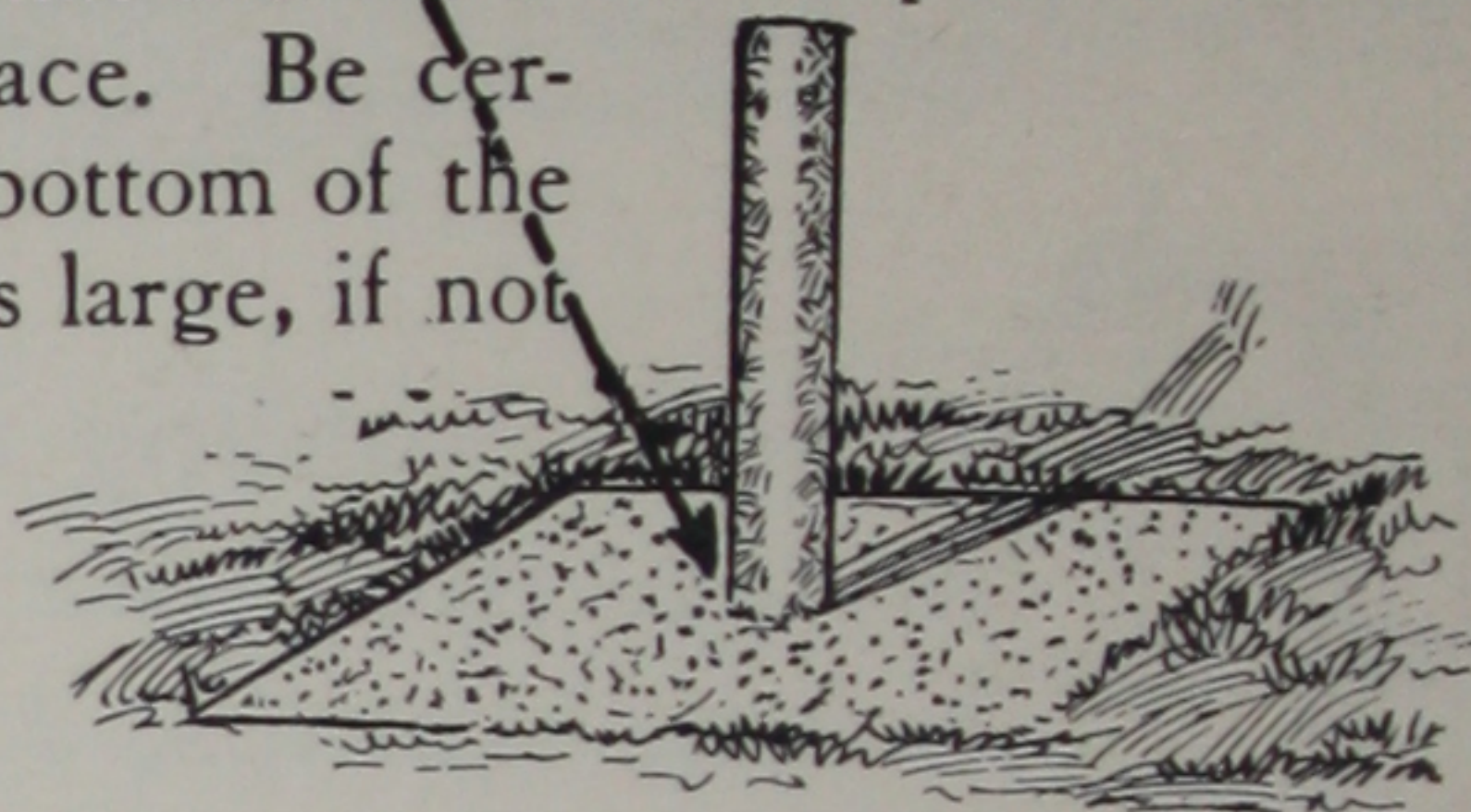






Posts should not extend above the top wire of the fence more than 2 inches.

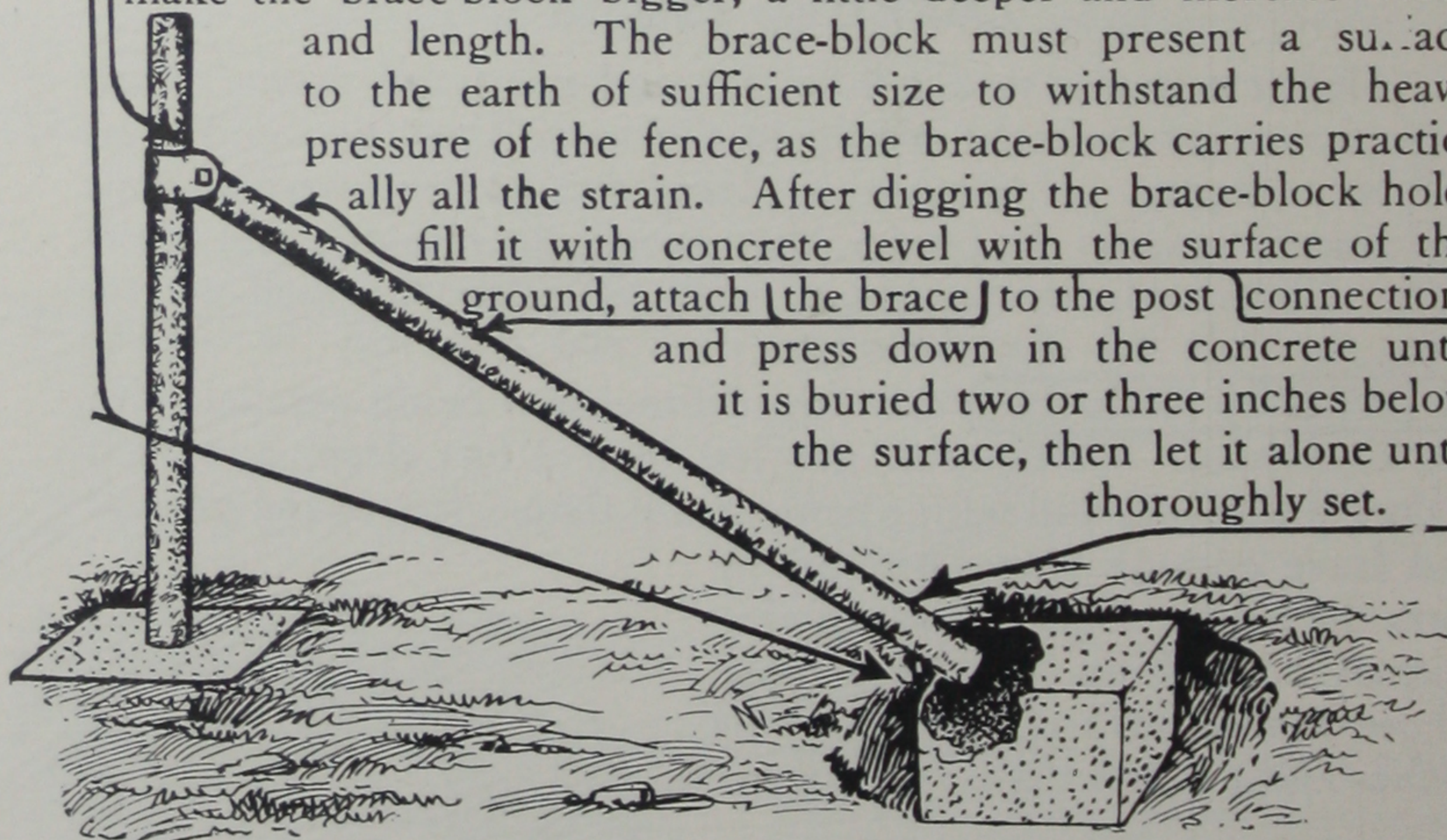
After digging the hole for the end post, make a mark on the post, measuring from the top, indicating how far the post should be set in the ground. For instance, if the fence is to be 47 inches high place the mark 49 inches from the top of the post. Put the post in the middle of the hole and fill the hole with concrete level with the surface of the ground, making sure that the mark on the post is level with the surface. Be certain that the bottom of the post hole is as large, if not larger, than the top of the hole.



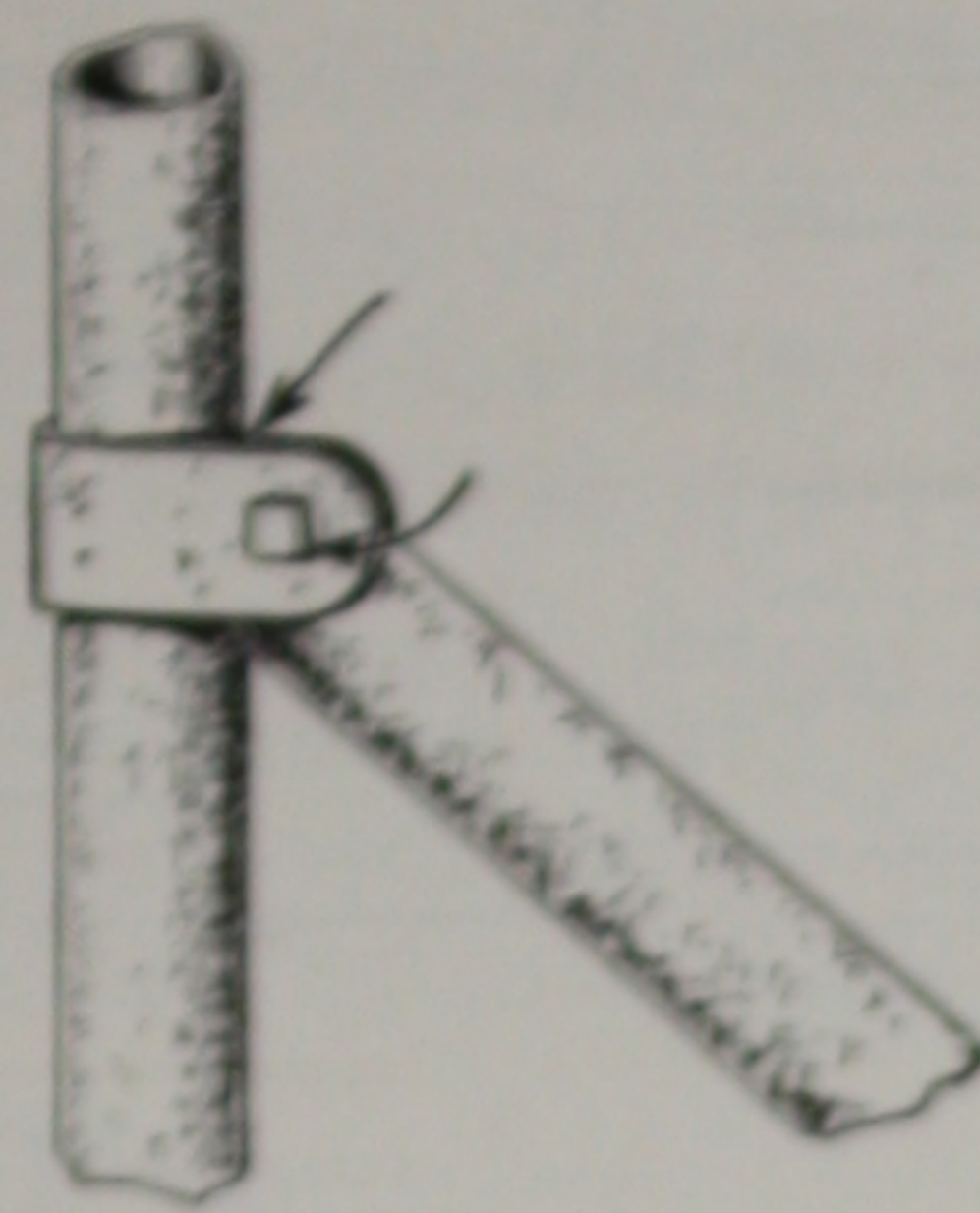
## Digging the Brace Block Hole

Without disturbing the concrete about the end post, slip the brace over the brace-connection, let the other end of the brace rest on the ground, and make a mark 2 or 3 inches nearer the post than the end of the brace.

This mark will be the edge of the brace-block hole next the post. Dig the brace-block hole the same width and length as the end post hole, and from 16 inches to 18 inches deep if the ground is reasonably firm. If the ground is quite soft and yielding, make the brace-block bigger, a little deeper and increase width and length. The brace-block must present a surface to the earth of sufficient size to withstand the heavy pressure of the fence, as the brace-block carries practically all the strain. After digging the brace-block hole, fill it with concrete level with the surface of the ground, attach the brace to the post connection, and press down in the concrete until it is buried two or three inches below the surface, then let it alone until thoroughly set.







Best results are usually obtained by setting top of brace collar about 14 or 15 inches from top of post, but in no case should the collar be lower than  $\frac{1}{3}$  the distance from the top of the post to the ground line. Before stretching, be sure that the nut on the brace collar is turned up very securely. This collar must be tight or it will slip.

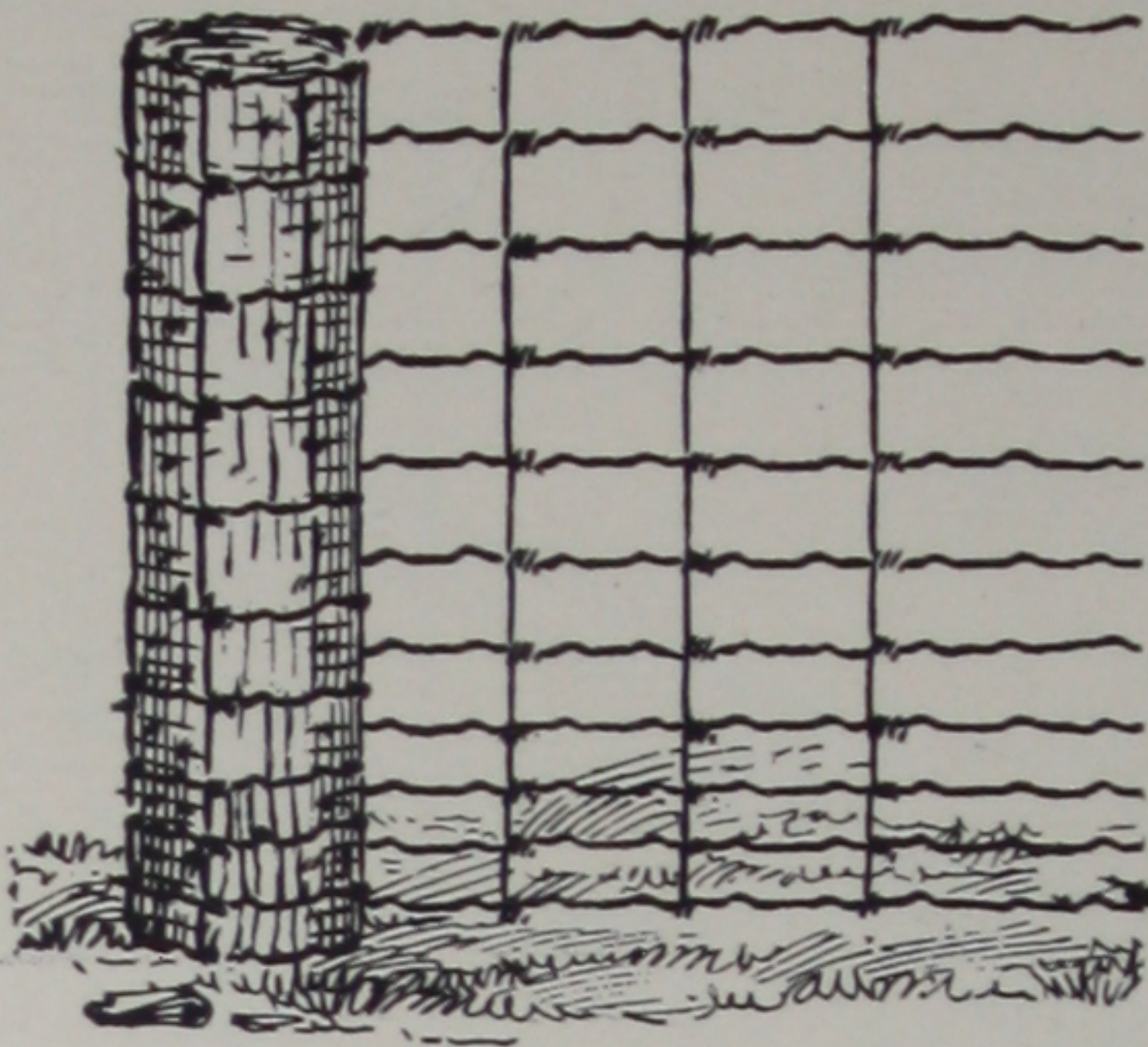
### Driving American Line Posts



In driving American line posts be sure and use a driving cap. Your dealer can supply you. By placing it on top of the post before driving you can strike solid blows with any type of maul or sledge. A convenient way to drive posts is to work from a wagon bed as it is of the proper height and gives a firm footing. To make certain of getting your line posts in a straight line, we suggest the use of a cotton cord stretched between the end or corner posts.

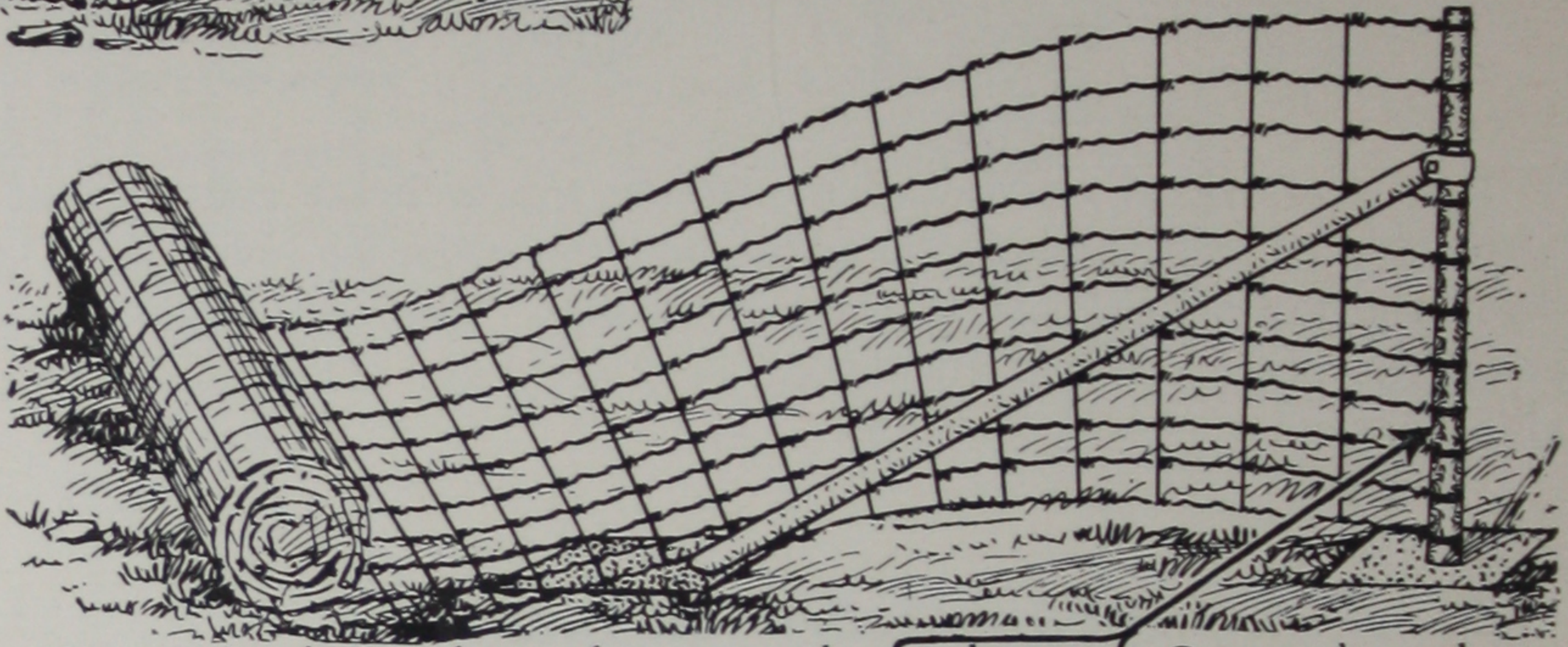
Banner, railroad rail construction, line posts can be driven in same way, only Driving Cap is unnecessary.





### American End and Corner Posts

Do not attempt to stretch fence until the concrete about the ends and corners is thoroughly set. First, unroll the fence on the ground with the bottom bar next to the posts. Trim the stay wires from the ends of the fabric, as shown.



Fasten the bars of the fence to the **end post**. Go to the other end post and pull as much as possible of the slack out of the fence while it is lying on the ground. Attach stretcher bar to the fence so that when the stretching is done, the **stretcher bar** will be from 2 to 4 feet from the end post. Put in a

**wood dummy post** 4 or 5 feet back of the steel end post and then insert a good **heavy brace**,

letting one end of the brace rest on the **brace collar** of the steel post, attach

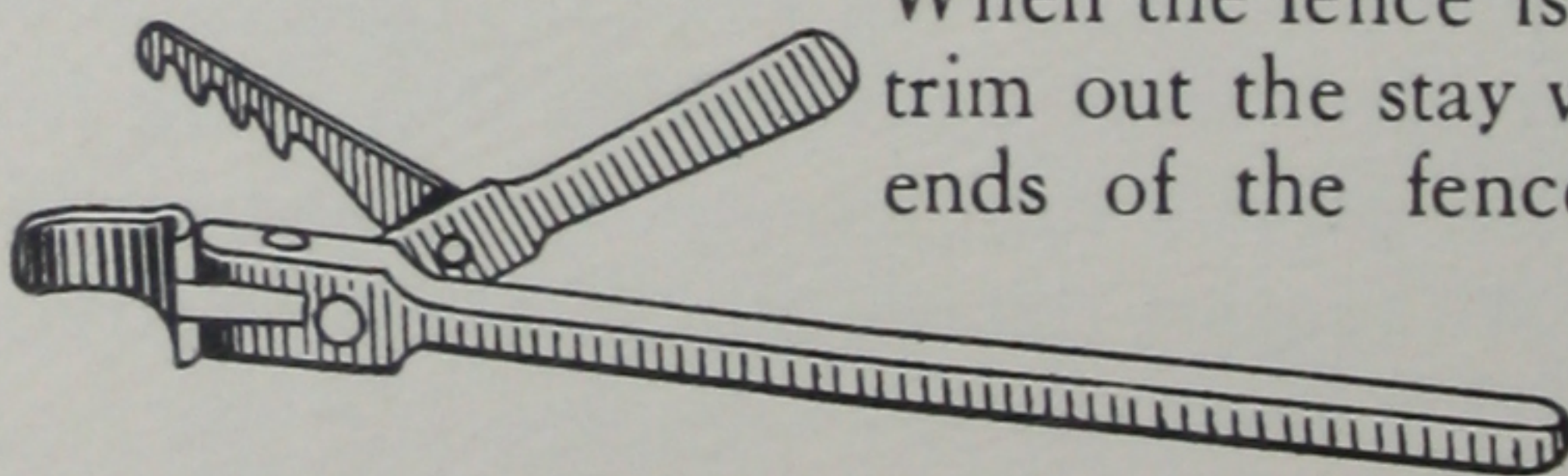
the **stretcher chain** to this dummy post, working the **stretcher head** between the dummy post and the steel post. While stretching, lift the fence off the ground occasionally between the end posts so as to relieve the friction and let the fence distribute itself over the line.

When the fence is stretched tight, trim out the stay wires so that the ends of the fence may be wrapped about the

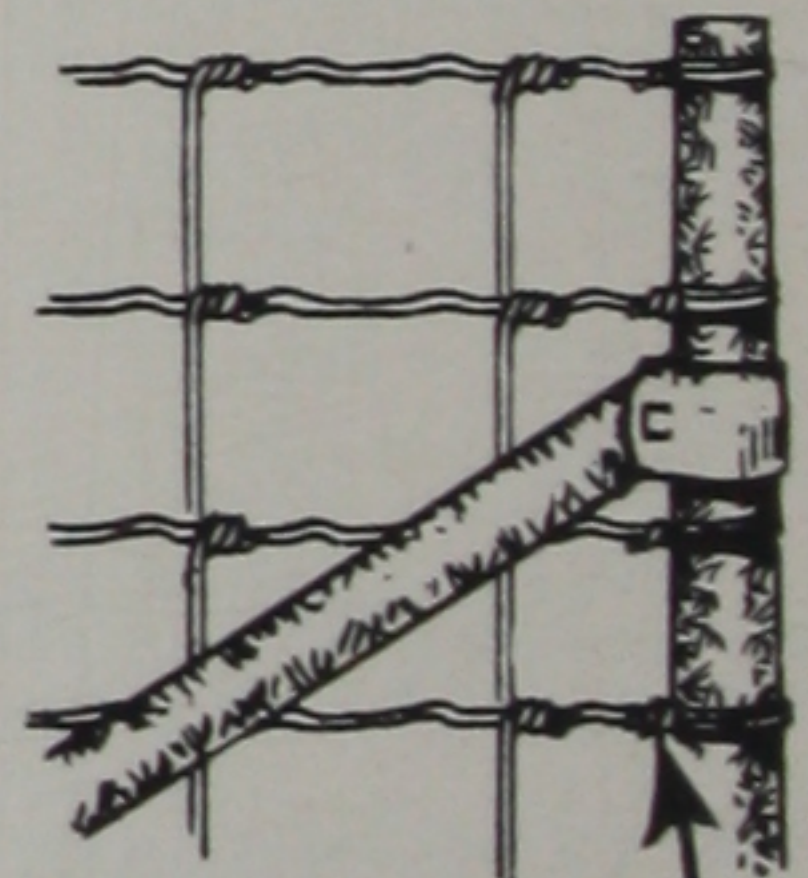
posts to make a neat job.

Use the **Perfection End Tool** or some other tool

and draw the **bars** of the fence tightly about the end post, splicing the ends about the bar itself, as indicated.



Perfection  
End Tool



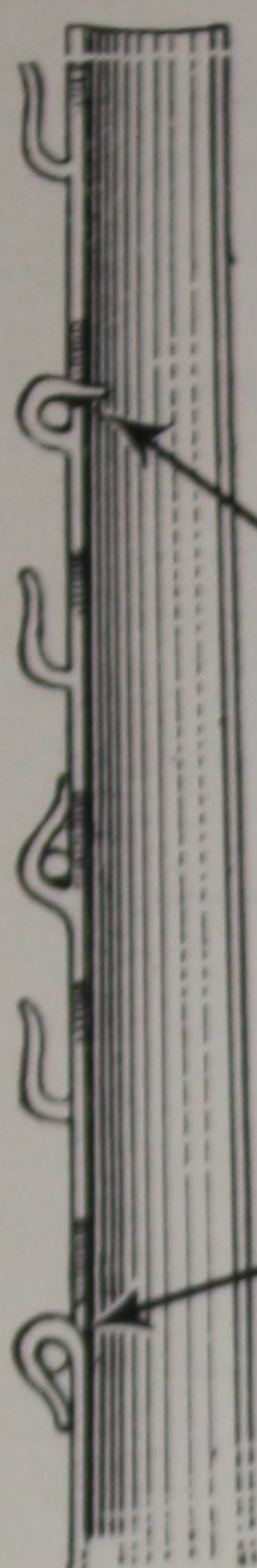


## Fastening Fence to American Line Posts

It is not necessary that all wires of the fence be fastened to line posts.

Fasten the top bar of the fence in the top tongue of the line posts, driving the tongue well backward over the wire. Then fasten as many wires as convenient and the fence will stay all right.

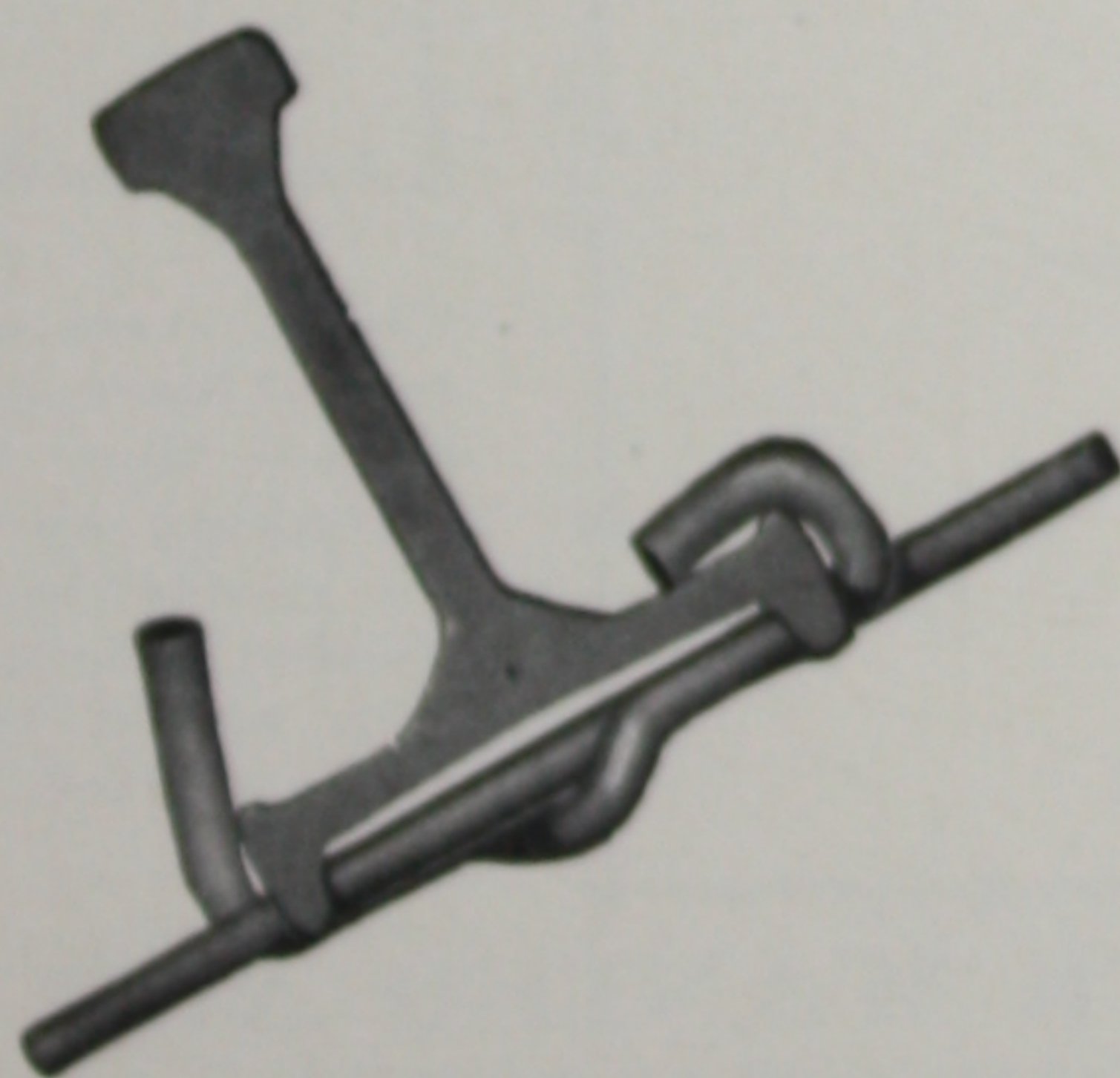
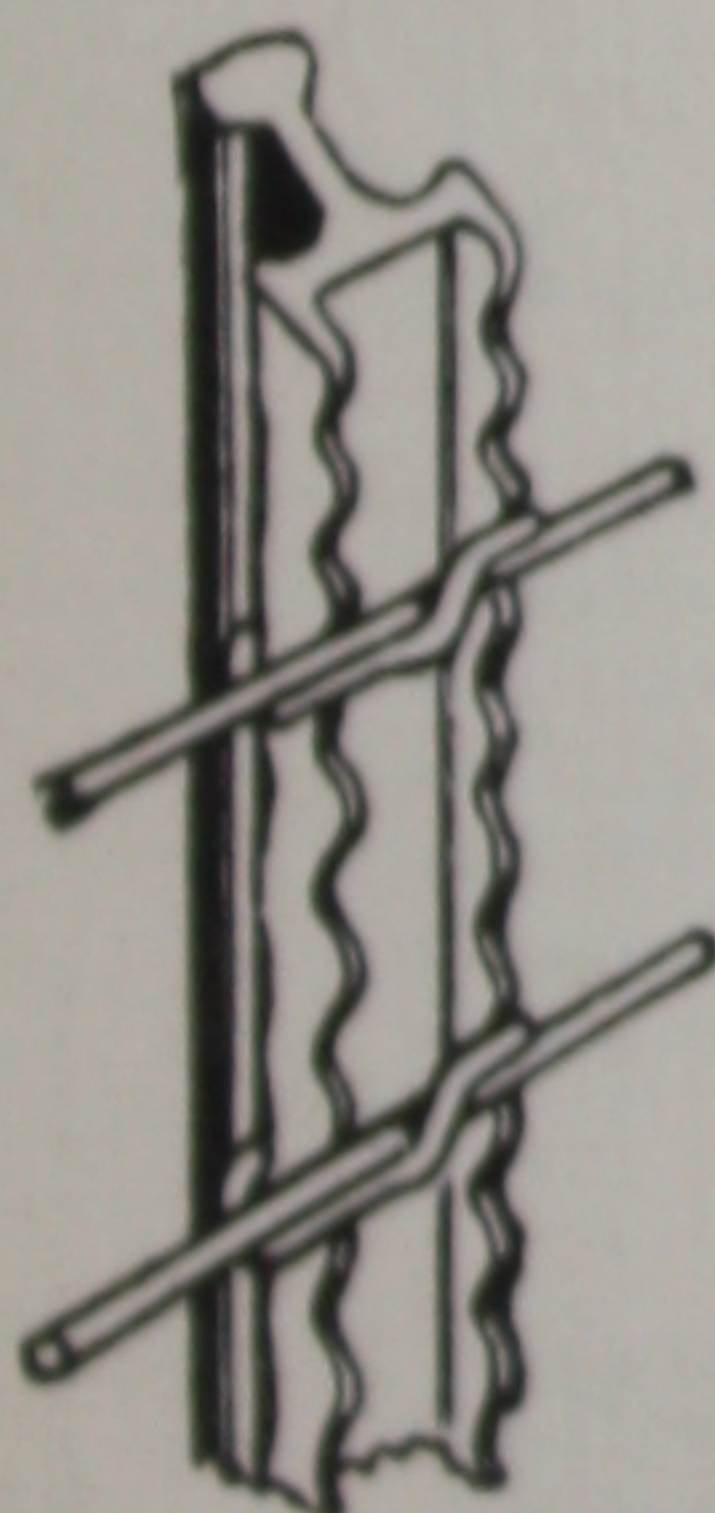
If one half or two thirds of the wires are fastened to the post it is sufficient. Do not turn tongues down over the wire unless necessary. However, the tongues can be turned down if properly handled, but it is much harder on the metal. When the fence has been completely fastened, remove the stretcher and the job is finished.



## Method of Attaching Fence to Banner Line Posts

A continuous series of lugs are rolled along both sides of the face of the tee. These lugs are spaced every  $\frac{3}{4}$ -inch and on account of this close spacing, it is possible to securely fasten every line wire of a woven fence if that is desired. While these lugs securely hold the fence wires from moving up or down, they also hold them away from the face of the post, thus preventing the accumulation of dirt and moisture. Under ordinary conditions it is considered ample if every other wire is stapled to the post.

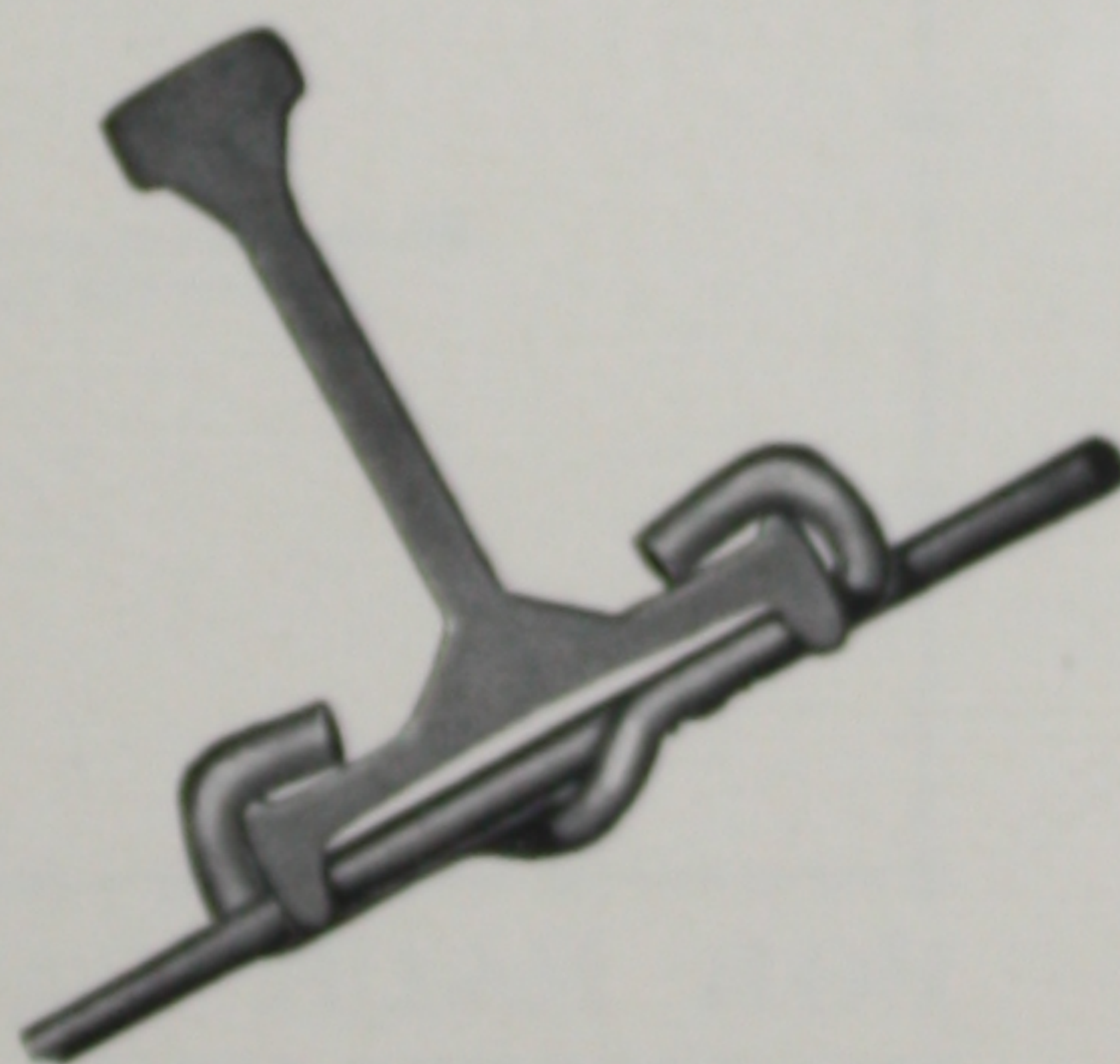
The Banner Galvanized Clamp comes ready to be attached. No special tools necessary. A hammer or ordinary pliers will do. Wire can be securely fastened in a few seconds. Seven furnished free with each post.



The Banner Clamp and Method of Fastening

**Figure No. 1**

Shows Clamp in position before end has been bent over stem of post.

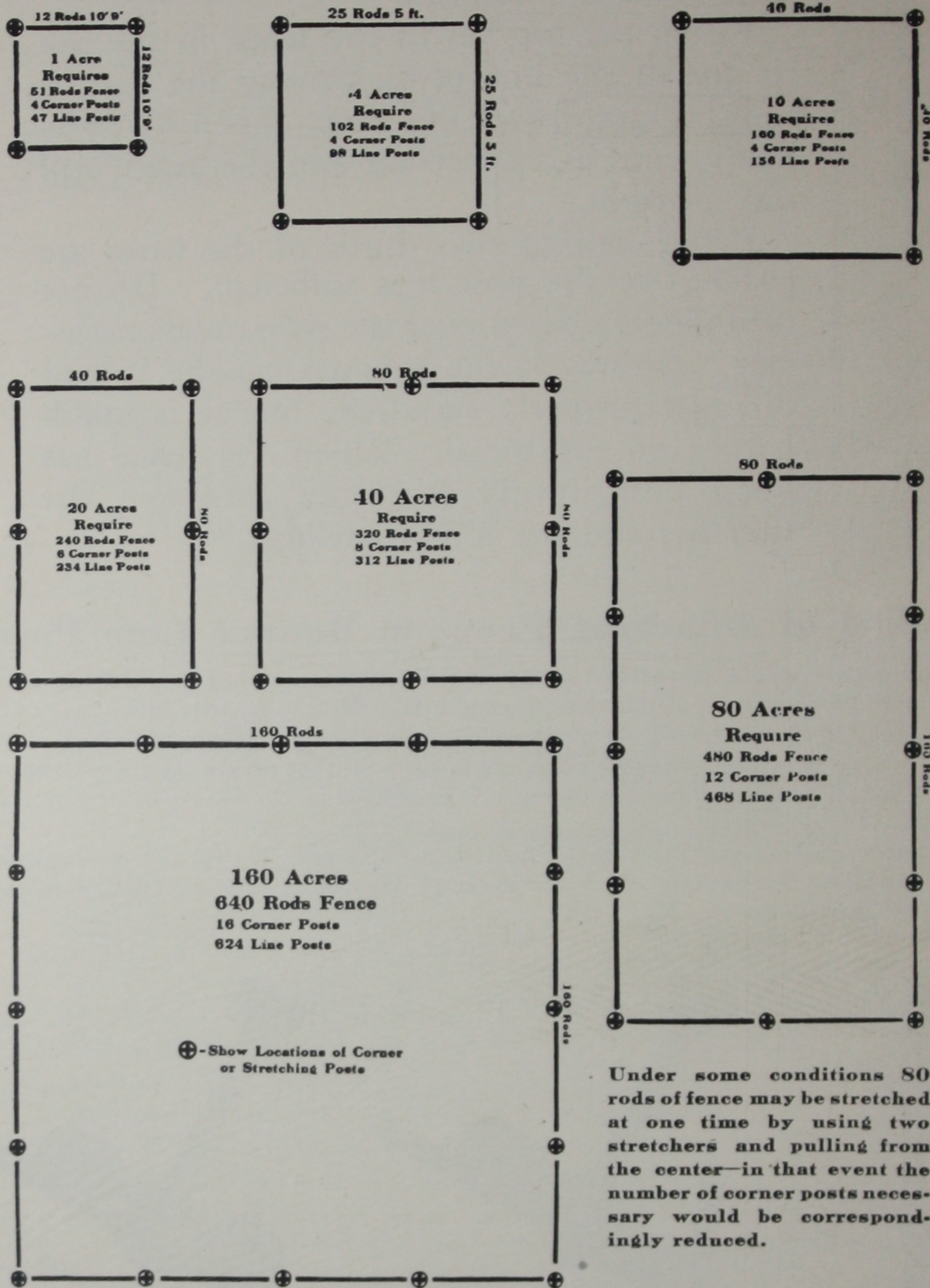


**Figure No. 2**

Shows Clamp after end has been bent over stem of post.



The following diagrams indicate the number of posts and rods of fence necessary to enclose fields of different sizes. Line posts are estimated to be spaced 1 rod apart. Where fence is subjected to severe strain and it is found advisable to set them at closer intervals, number of line posts necessary should be increased accordingly.



Under some conditions 80 rods of fence may be stretched at one time by using two stretchers and pulling from the center—in that event the number of corner posts necessary would be correspondingly reduced.

**FOR EACH GATE WANTED ADD 2 END POSTS TO NUMBER OF POSTS REQUIRED**



## How to Order American Galvanized End or Gate and Corner Fence Posts

State Quantity, Length, Gauge, Style of Post, and whether Plain or Ornamental Top.

*For example:* 50-8 ft. No. 8 Gauge American End or Gate Posts, Plain Top.

25-8 ft. No. 8 Gauge American Corner Posts, Ornamental Top.

## How to Order American Galvanized Smooth Steel Posts

State Quantity, Length, Gauge, Specifications, and whether Plain or Ornamental Top.

*For example:* 100-9 ft. No. 8 Gauge American Smooth Steel Posts, Plain Top.

## How to Order American Tubular Steel Gates

In ordering American Tubular Steel Gates, specify:

Quantity.

Width of Opening (in feet).

Height (in inches).

Style of Gate (Walk, Drive, Tilting, etc.).

Whether Galvanized or Painted Frame.

Whether Standard or Lawn.

Whether Plain or Ornamental Top.

Fixtures desired (Whether for Wood or Steel Posts).

*For Example:*

3- 3 ft.x50 in. Walk Gates, Galvanized Frame, Ornamental Top, for Steel Posts.

3-10 ft.x50 in. Single Drive Gates Painted Frame, Plain Top, for Wood Posts.

3-14 ft.x50 in. Chain Latch Tilting Gates, Galvanized Frame, for Steel Posts.